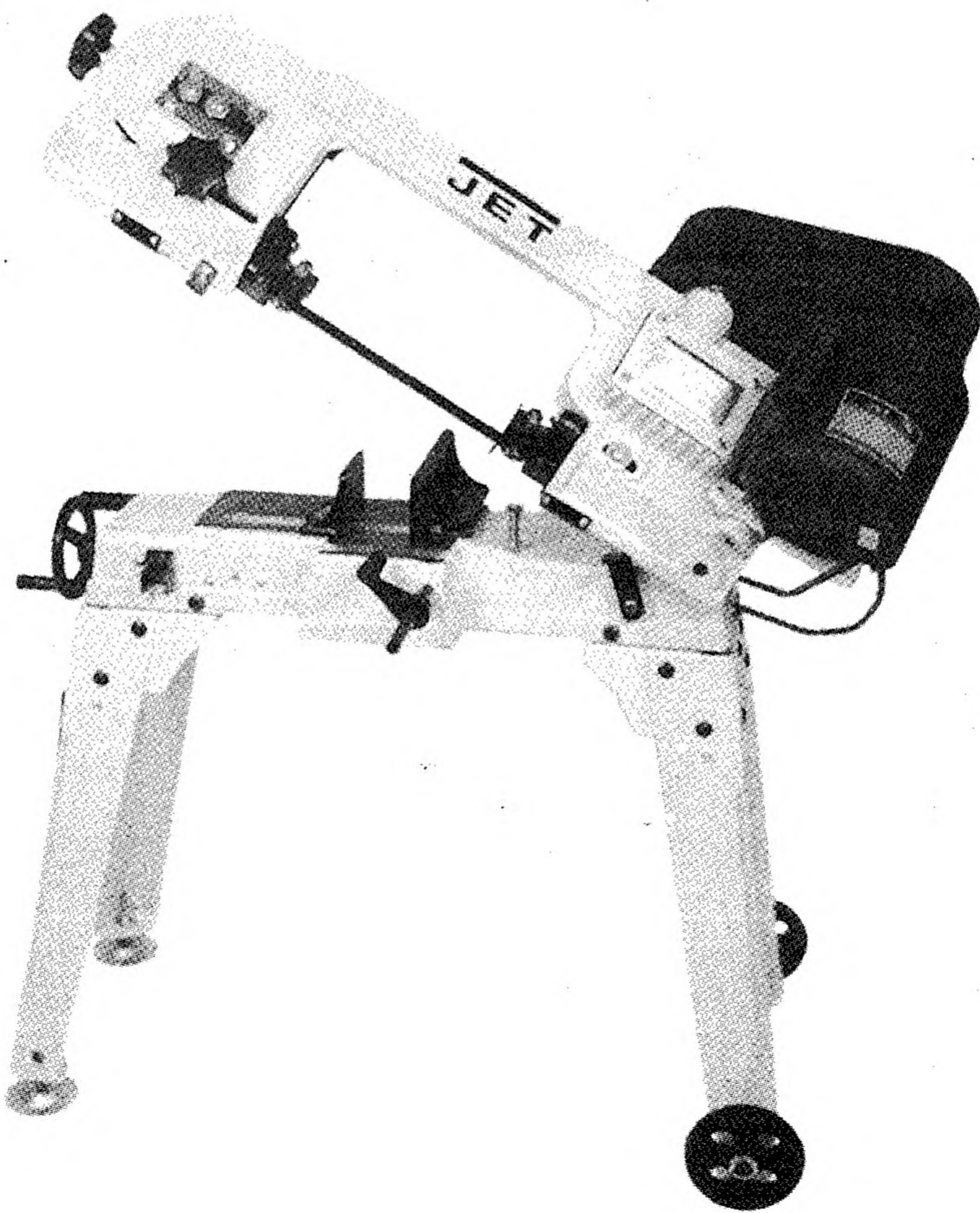




Operating Instructions and Parts Manual

Horizontal/Vertical Bandsaw

Model: HVBS-56M



WMH TOOL GROUP
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Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

Part No.: M-414458
Revision G 11/03
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This manual has been prepared for the owner and operators of a JET HVBS-56M. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your Bandsaw, and to aid in using the machine safely, read this manual thoroughly and follow instructions carefully.

Warranty & Service

The WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these WMH Tool Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Performax, Wilton, or Powermatic tools.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848, or visit www.wmhtoolgroup.com

More Information

Remember, the WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit www.wmhtoolgroup.com

WMH Tool Group Warranty

The WMH Tool Group (including Performax, Wilton and Powermatic brands) makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: **1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE.** This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at JET'S expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET'S warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights which vary from state to

The WMH Tool Group sells through distributors only. Members of the WMH Tool Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

⚠ WARNING

**Read and understand the entire instruction manual before operating machine.
This machine is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper safe use of bandsaws, do not use this machine until proper training and knowledge has been obtained.**

"Warning: For your own safety read instruction manual before operation saw"

- (a) Wear eye protection.
- (b) Do not remove jammed cut off pieces until blade has stopped.
- (c) Maintain proper adjustment of blade tension, blade guides, and trust bearing.
- (d) Adjust upper guide to just clear workpiece.
- (e) Hold workpiece firmly against table.

1. Keep guards in place and in working order.
2. Remove adjusting keys and wrenches. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
3. Keep work area clean. Cluttered areas and benches invite accidents.
4. Don't use in dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. Keep children away. All visitors should be kept safe distance from work area.
6. Make workshop kid proof with padlocks, master switches, or by removing starter keys.
7. Don't force tool it will do the job better and safer at the rate for which it was designed.
8. Use right tool don't force tool or attachment to do a job for which it was not designed.
9. Use proper extension cord. Made sure your extension cord is in good condition. When using an extension cords, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in voltage resulting in loss of power and overheating. Table shows the correct size to use depending on cord length and nameplate ampere rating. If in double, use the next heavier gage. The smaller the gage number, the heavier the cord.
10. Wear proper apparel do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
11. Always use safety glasses. Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. Secure work. Use clamp or a vise to hold work when practical. It is safer than using your hand and it frees both hands to operate tool.
13. Don't overreach. Keep proper footing and balance at all times.
14. Maintain tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. Disconnect tools before servicing; when changing accessories, such as blades, bits, cutters and the like.
16. Reduce the rise of unintentional starting. Make sure switch is in off position before plugging in.
17. Use recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to person.
18. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint
 - crystalline silica from bricks and cement and other masonry products, and
 - arsenic and chromium from chemically-treated lumber.
19. Never stand on tool serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
20. Check damaged parts. Before further use the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

21. Direction of feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
22. Never leave tool running unattended. Turn power off. Don't leave tool until it comes to a complete stop.

Table
Minimum gage for cord

| Ampere Rating | | Volts | Total length of cord in feet | | | |
|--|------|-------|------------------------------|--------|-----------------|--------|
| | | 120V | 25 ft. | 50ft. | 100ft. | 150ft. |
| | | 240V | 50ft. | 100ft. | 200ft. | 300ft. |
| Not | | | | | | |
| More | More | | | | | |
| Than | Than | | | | | AWG |
| 0 | 6 | | 18 | 16 | 16 | 14 |
| 6 | 10 | | 18 | 16 | 14 | 12 |
| 10 | 12 | | 16 | 16 | 14 | 12 |
| 12 | 16 | | 14 | 12 | Not Recommended | |
| Only the applicable parts of the Table need to be included, For instance, a 120-volt product need not include the 240-volt heading | | | | | | |

Grounding Instructions

Caution: This tool must be grounded while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

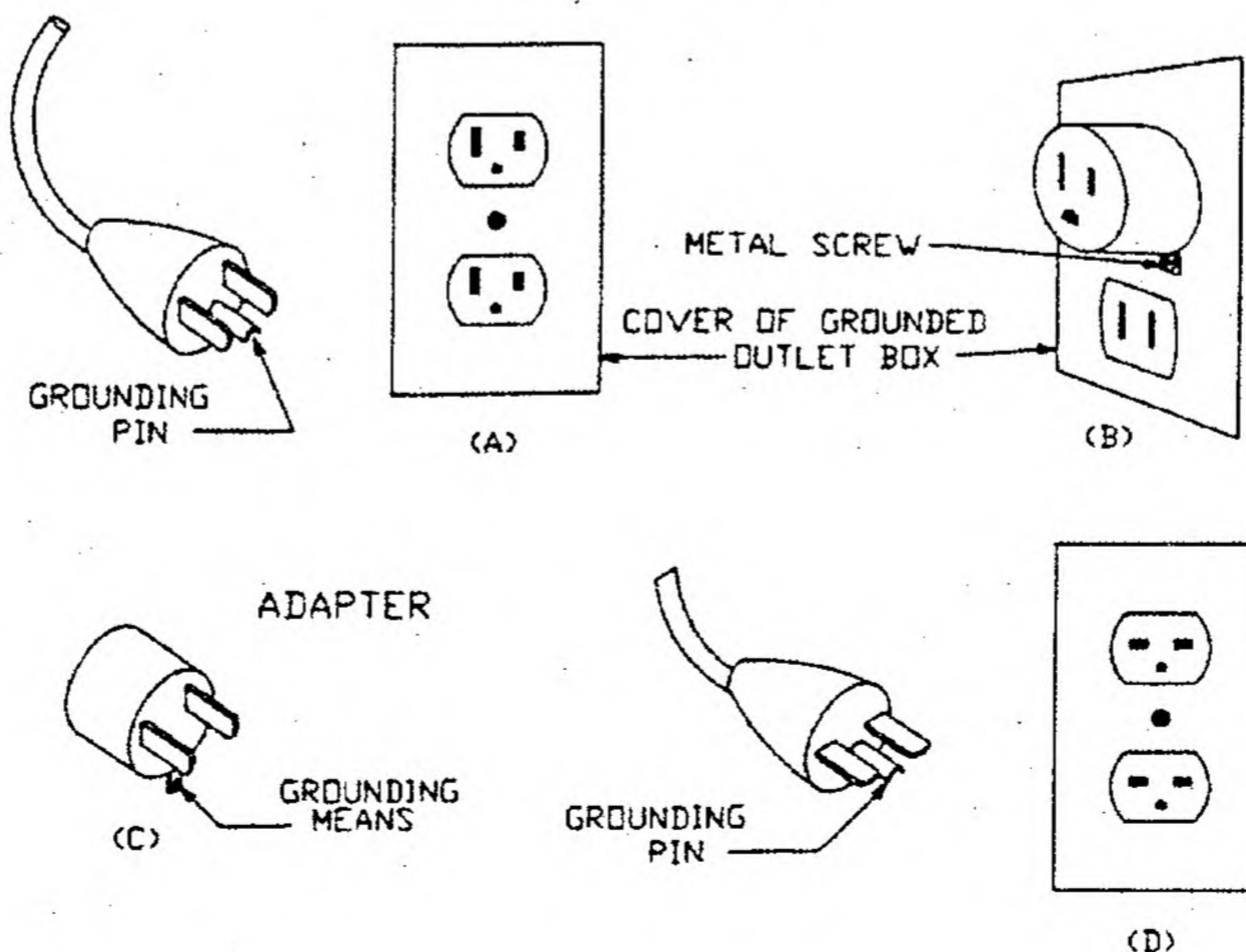
Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Repair or replace a damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch A. The tool has a grounding that looks like the plug illustrated in sketch A. A temporary adapter, which looks like the adapter illustrated in sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in sketch B if a properly until a properly grounded outlet can be installed by a qualified electrician. (This adapter is not permitted in Canada) The green-colored rigid ear, lug, the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in sketch D. The tool has a grounding that looks like the plug illustrated in sketch D. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this tool. If the tool must be reconnected for use on a different type of electric circuit, the reconnection should be made by qualified service personnel; and after reconnection, the tool should comply with all local codes and ordinances.

Grounding methods



The conversion from 115V to 230V operation must be done by a qualified electrician.

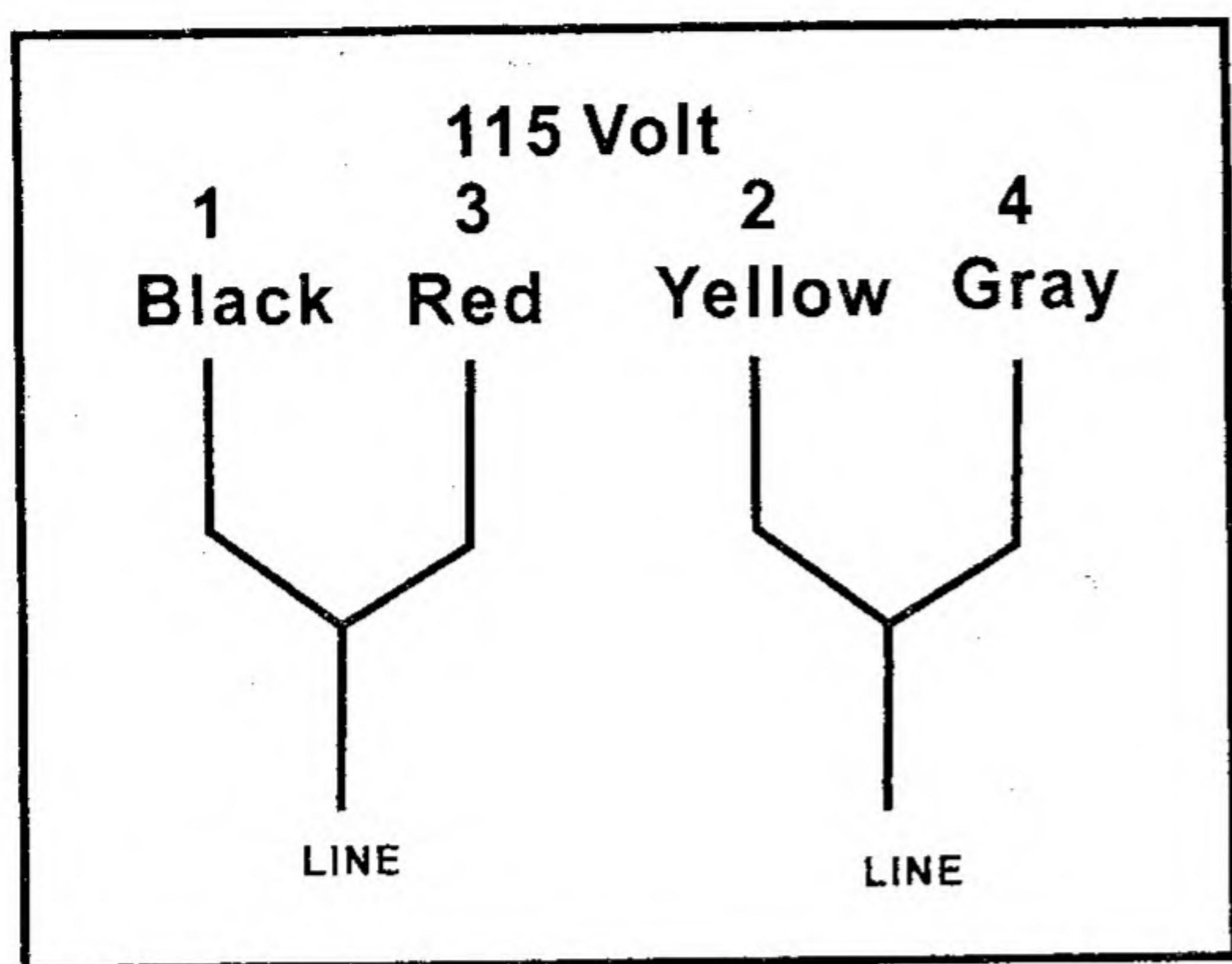


Chart 1

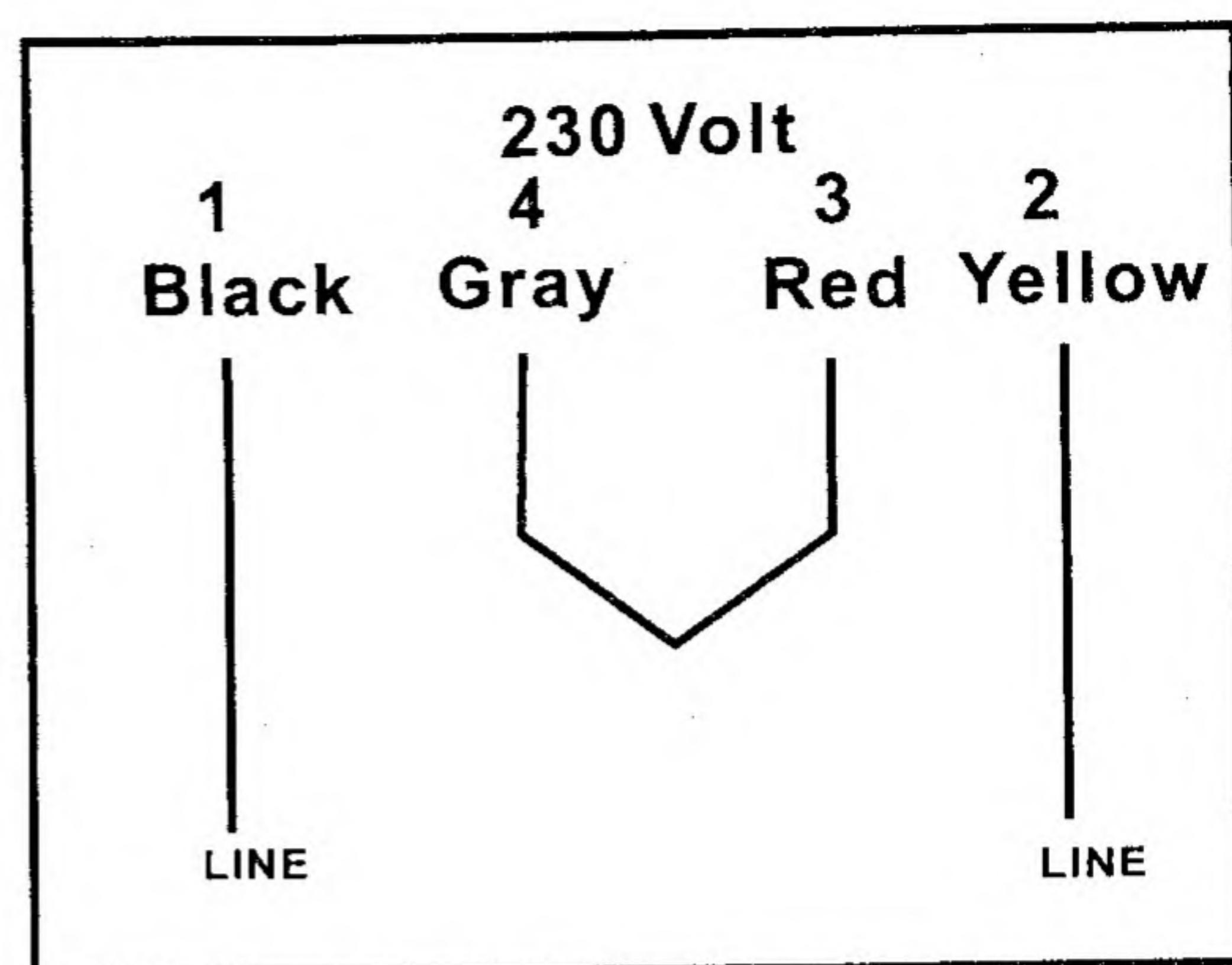


Chart 2

Specifications:**HVBS-56M**

| | |
|-------------------------------|---------------------------------------|
| Stock Number..... | 414458 |
| Horizontal Capacity: | |
| Round @ 90°..... | 5" |
| Round @ 45°..... | 3" |
| Rectangle @ 90°..... | 5" x 6" |
| Rectangle @ 45°..... | 5" x 3" |
| Throat Depth..... | 6" |
| Vertical Work Table Size..... | 9-5/8" x 9-1/2" |
| Vise Swivels..... | 45° |
| Blade Size..... | 1/2" x 0.025" x 64-1/2" |
| Blade Wheel Diameter..... | 7-3/8" |
| Speeds..... | 80, 120, 200 SFPM |
| Bed Height..... | 25-1/2" |
| Floor Space Required..... | 16-1/4" x 42-1/2" |
| Motor (UL listed) | 1/2 HP, 1 Ph, 115/230V, prewired 115V |
| Net Weight (approx.)..... | 115 lbs. |

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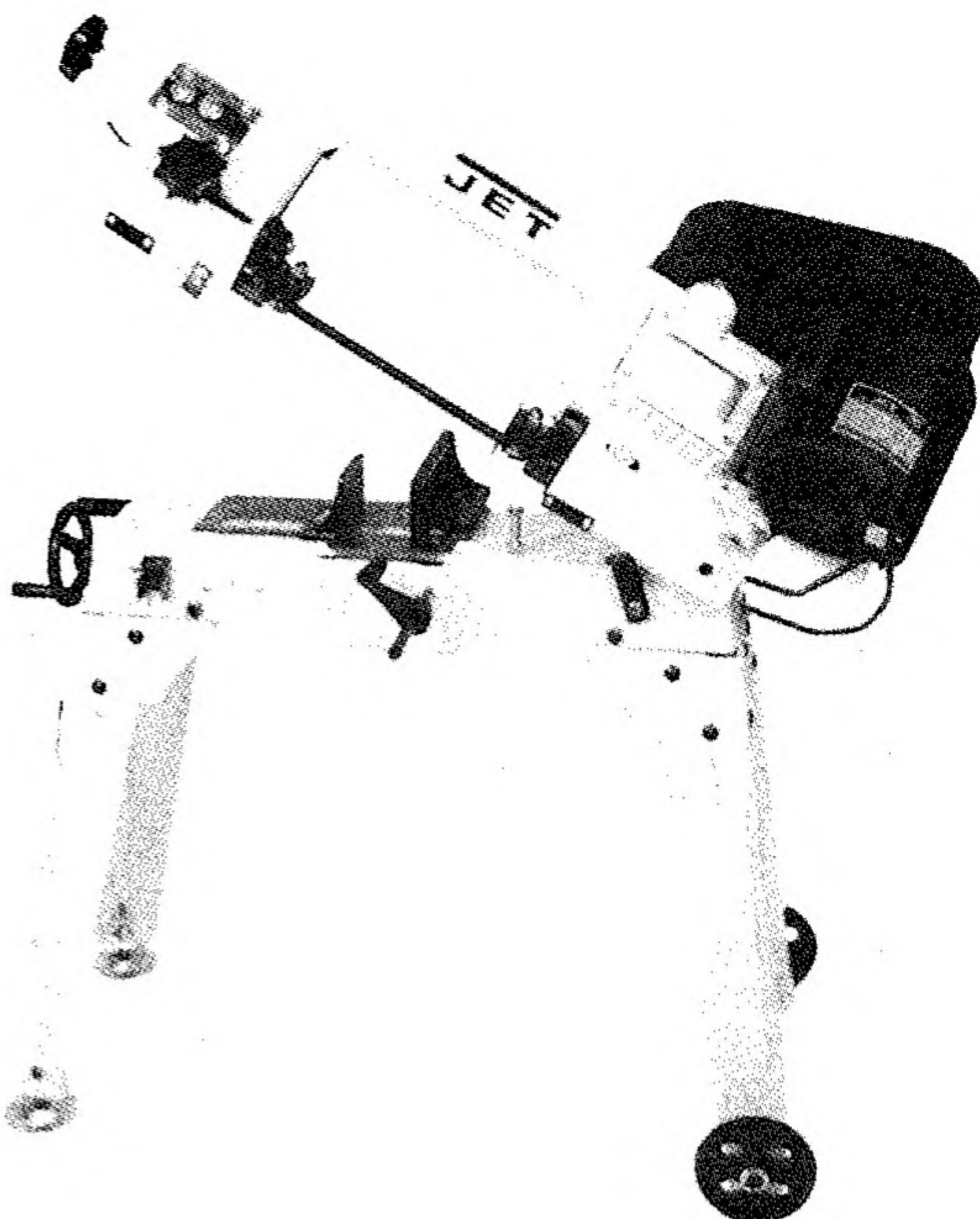
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The specifications in this manual are given as general information and are not binding. JET Equipment & Tools reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Unpacking and Clean-Up

Note: Read and understand the entire manual before attempting setup or operation.

1. Remove all contents form the shipping carton.
2. Inspect contents for shipping damage and report any damage to your distributor.
3. Wipe bed and vise assembly with clean cloth to remove excess oil used to prevent rust.
4. Do not discard any packing material until saw has been assembled and is running properly.



Tools Supplied for Assembly

1. Wrench 12/14mm
2. 4mm Angle Hex Wrench

Tools Required for Assembly

- #2 Cross Point Screwdriver
- 6-8" Adjustable Wrench or Wrench Set
- Pliers - Regular or Needle Nose
- Ratchet and Sockets will Speed Assembly

Assembly

1. With the help of another person turn the saw over so that it rests on the motor and saw bow, Figure 1. Place it on a piece of cardboard, or a surface that will not damage the saw.
2. Attach a cross brace (A, Fig. 1) to the motor side of the bed using three 5/16"x1" hex cap bolts, six 5/16" flat washers, and secure with three 5/16" hex nuts. **Hint:** Tighten the nut (B, Fig. 1) on the end of the bed first followed by the nuts on the sides.
3. Attach a leg to the cross brace using four 5/16"x3/4" carriage bolts, four 5/16" flat washers and four 5/16" hex nuts. Use a 12mm wrench to tighten. Repeat for other leg.
4. Remove the brace (C, Fig. 1) on the opposite end of the bed and bow using a 10mm wrench.

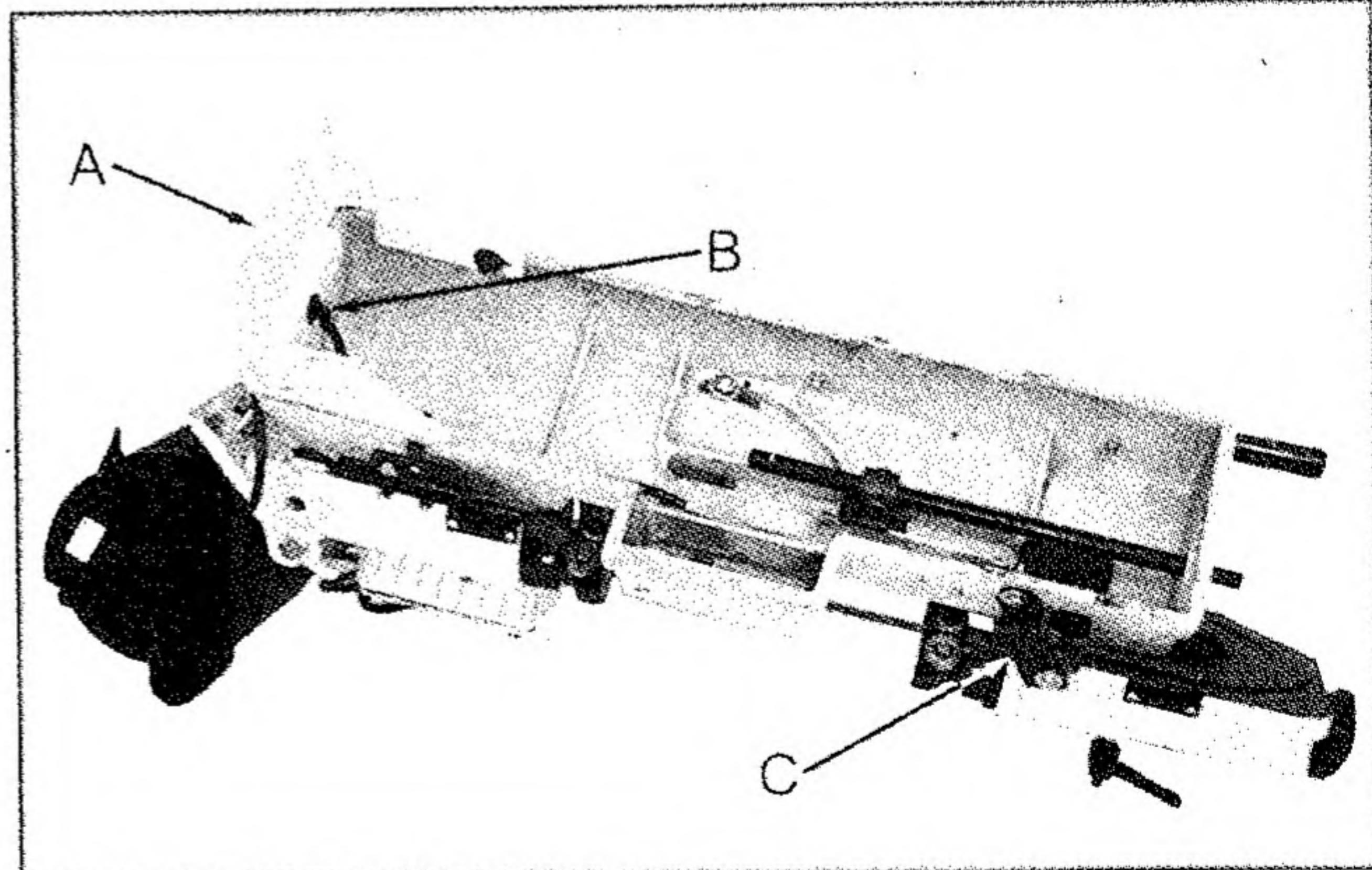


Fig. 1

5. Attach a cross brace to the opposite end of the bed using three 5/16"x1" hex cap bolts, six 5/16" flat washers, and secure with three 5/16" hex nuts. Tighten the nut on the end of the bed first followed by the nuts on the sides.

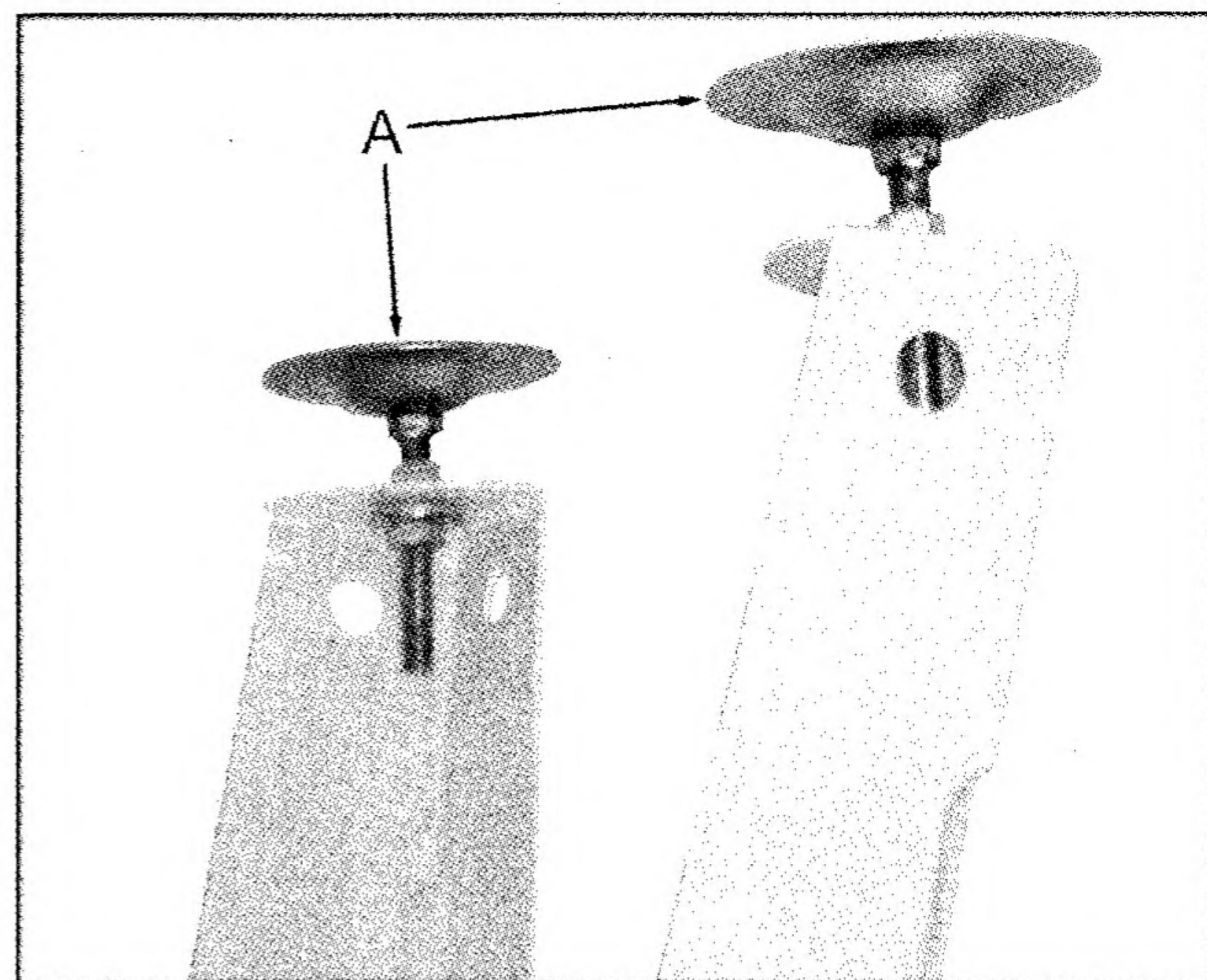


Fig. 2

6. Attach a leg to the cross brace using four 5/16"x3/4" carriage bolts, four 5/16" flat washers and four 5/16" hex nuts. Use a 12mm wrench to tighten. Repeat for other leg.

7. Attach the adjustable feet (A, Fig. 2) to the legs opposite of the motor, using the provided hardware.

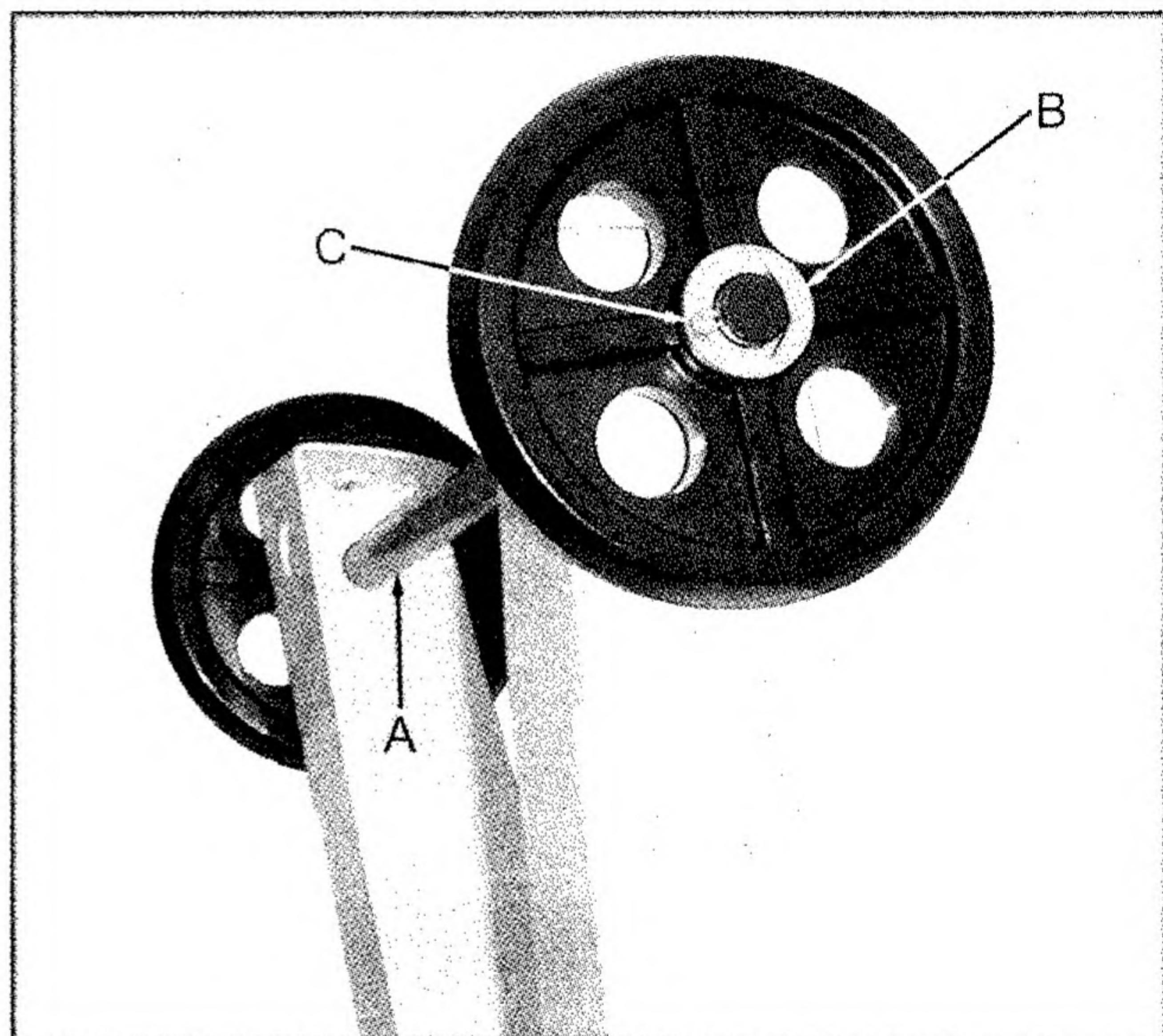


Fig. 3

8. Slide the axle (A, Fig. 3) through the legs. Place a large flat washer (B, Fig. 3) on both sides of the wheels and place on the axle. Secure wheels with two split pins (C, Fig. 3).

9. Carefully turn the saw onto its stand and adjust the feet so the bed is level.

10. Put the handle (A, Fig. 4) through holes in the stand legs opposite of the wheel assembly and secure with split pins.

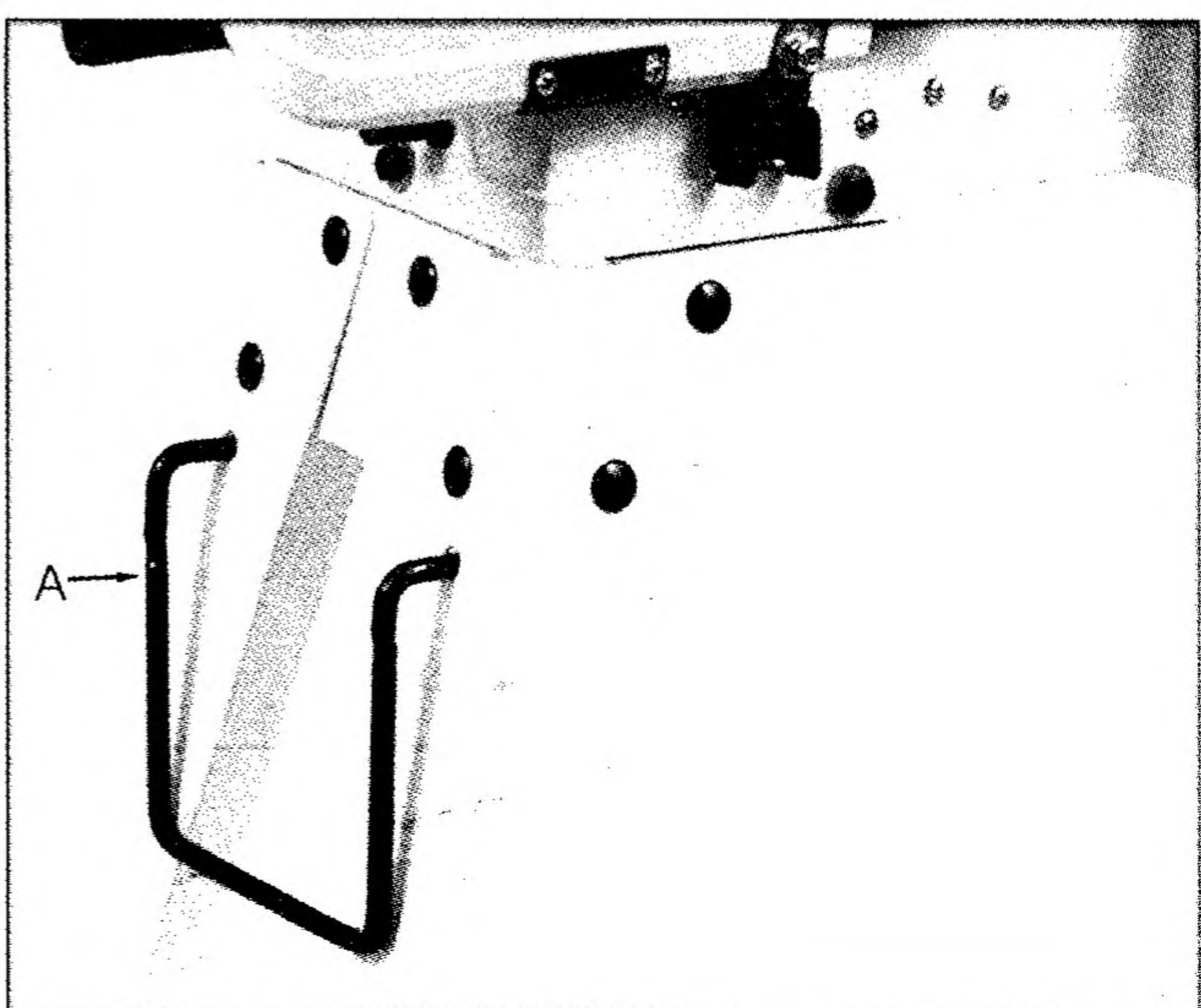


Fig. 4

11. Slide pulley cover (A, Fig. 5) around motor shaft and worm gear shaft. Secure with two hex cap screws and washers (B, Fig. 5).
12. Lift motor with one hand while the other hand places V-belt (C, Fig. 5) on both pulleys.
13. Attach the tension bracket (D, Fig. 5) to the saw bow with one 5/16"x3/4" hex head bolt and flat washer (E, Fig. 5).
14. Connect the two tension brackets with one 5/16"x3/4" carriage bolt, one 5/16" flat washers and one 5/16" hex nut (F, Fig. 5). **Hint:** Insert the carriage bolt from the inside so the hex nut is easy to access with a wrench.
15. Tension belt by pressing down on the motor while tightening hex nut (F, Fig. 5) until finger pressure on the belt between the two pulleys causes approximately 1/2" deflection. Close pulley cover. Don't over tighten the belt.
16. Insert stop rod (A, Fig. 6) into bed and tighten set screw (B, Fig. 6). Slide stock stop (C, Fig. 6) onto rod and tighten set screw (D, Fig. 6) to hold in place.
17. Slide handwheel (E, Fig. 6) onto shaft and secure by tightening set screw (F, Fig. 6). Make sure set screw seats on flat portion of shaft.

Vertical Cutting Plate Assembly

Note: These steps are only necessary when using the bandsaw in the vertical mode.

WARNING

Disconnect the bandsaw from the power source before making any repairs or adjustments!

Failure to comply may cause serious injury!

1. Disconnect the bandsaw from the power source.
2. Raise the arm to the vertical position and lock in place with lever (A, Fig. 7).
3. Loosen bolt (B, Fig. 7) and insert bracket (C, Fig. 7). Tighten bolt just enough to hold the bracket in place.

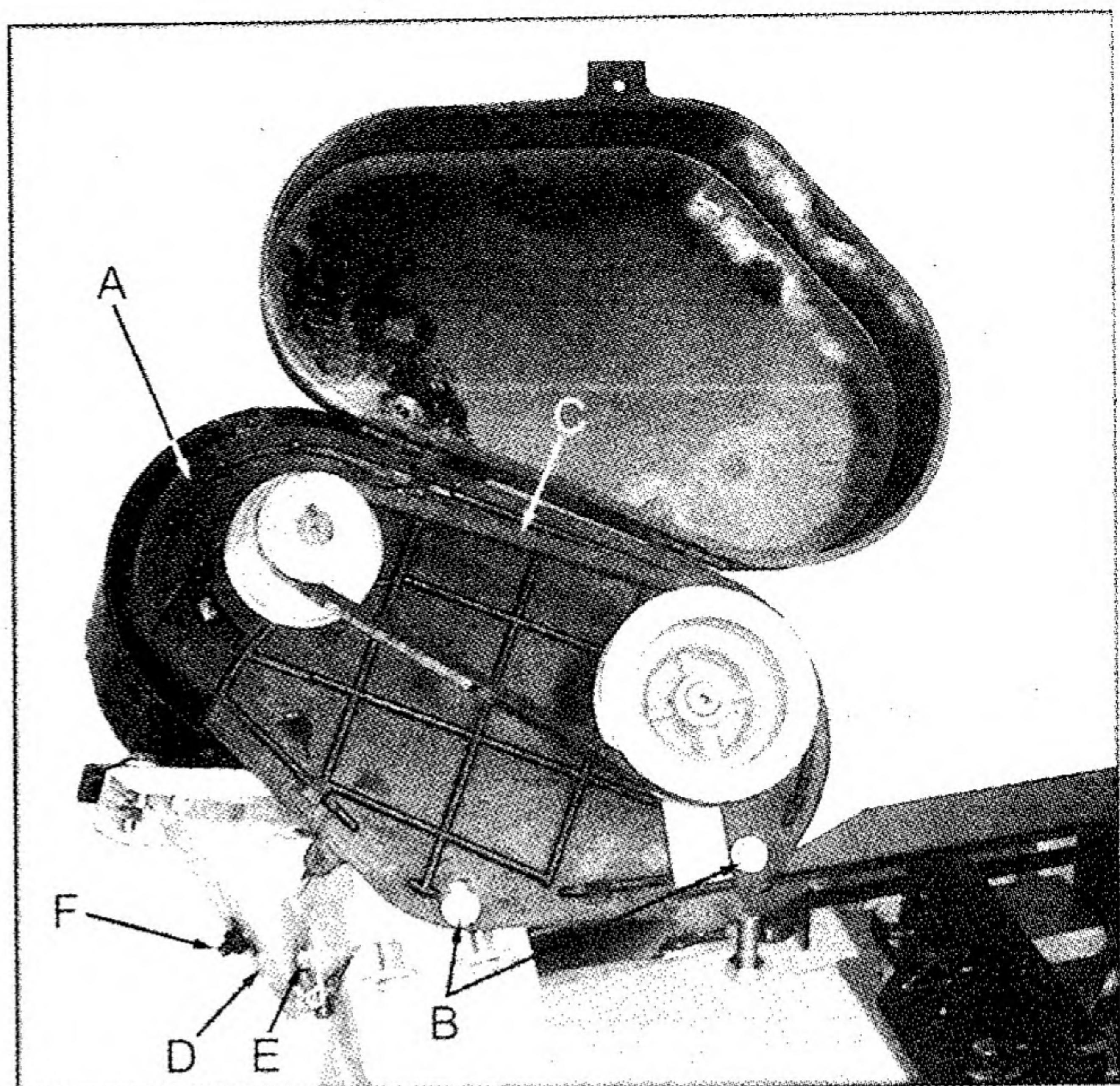


Fig. 5

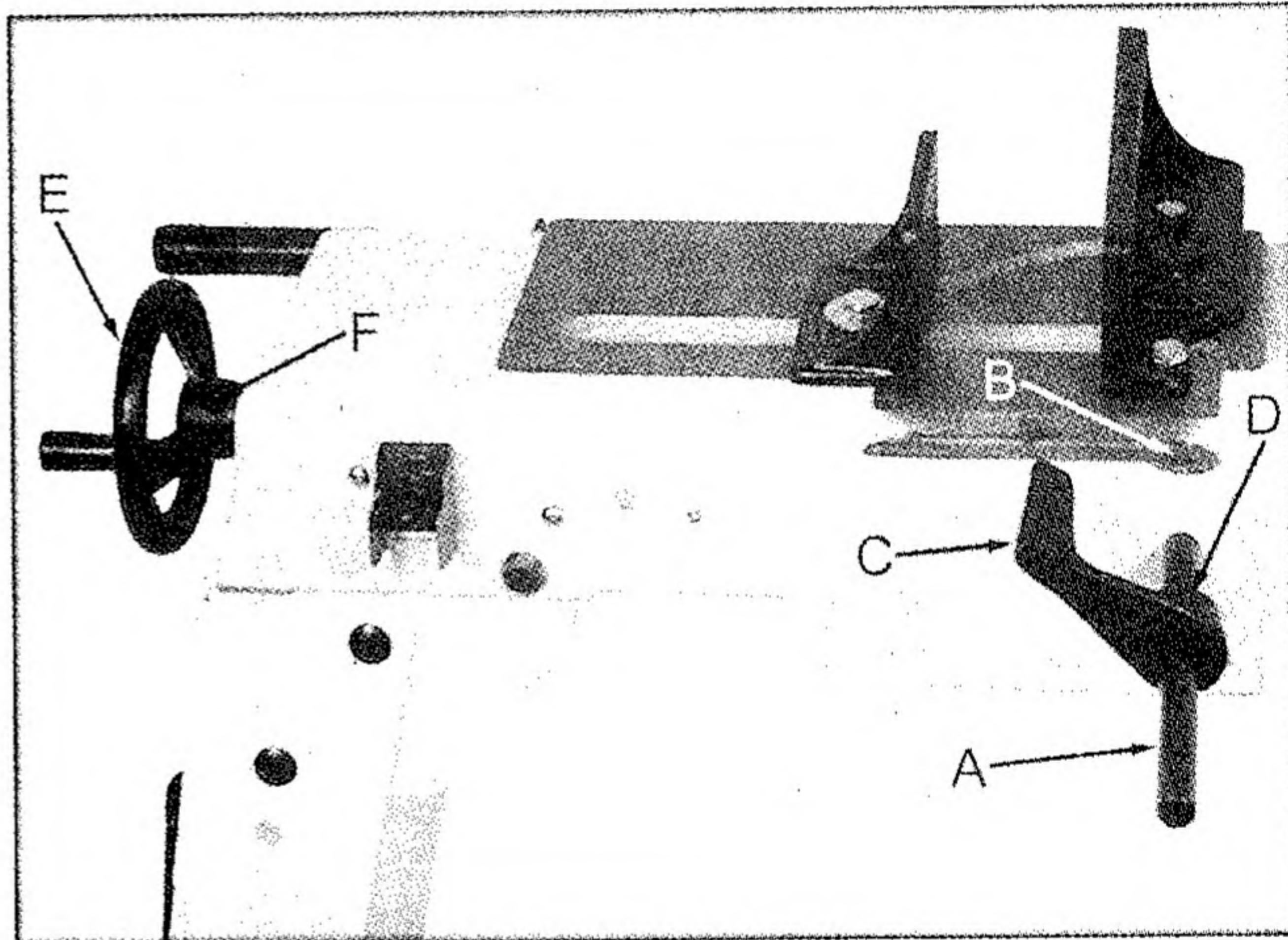


Fig. 6

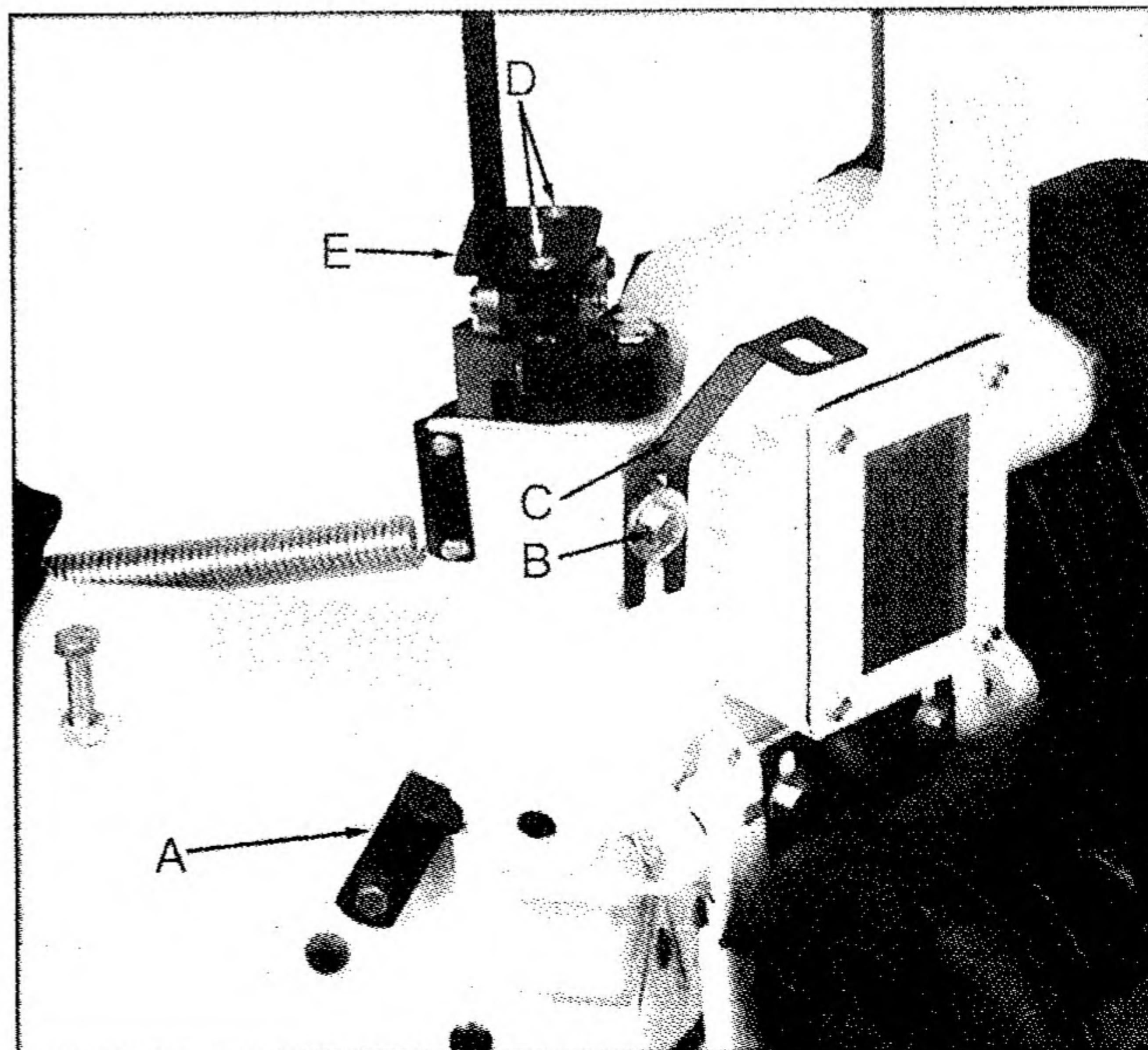


Fig. 7

4. Remove two screws (D, Fig. 7) and plate (E, Fig. 7).
5. Guide blade through slot in table (A, Fig. 8) and fasten table with two screws (B, Fig. 8).
6. Fasten support bracket to underside of table using screw (C, Fig. 8) and hex nut.
7. Tighten bolt (B, Fig 7).

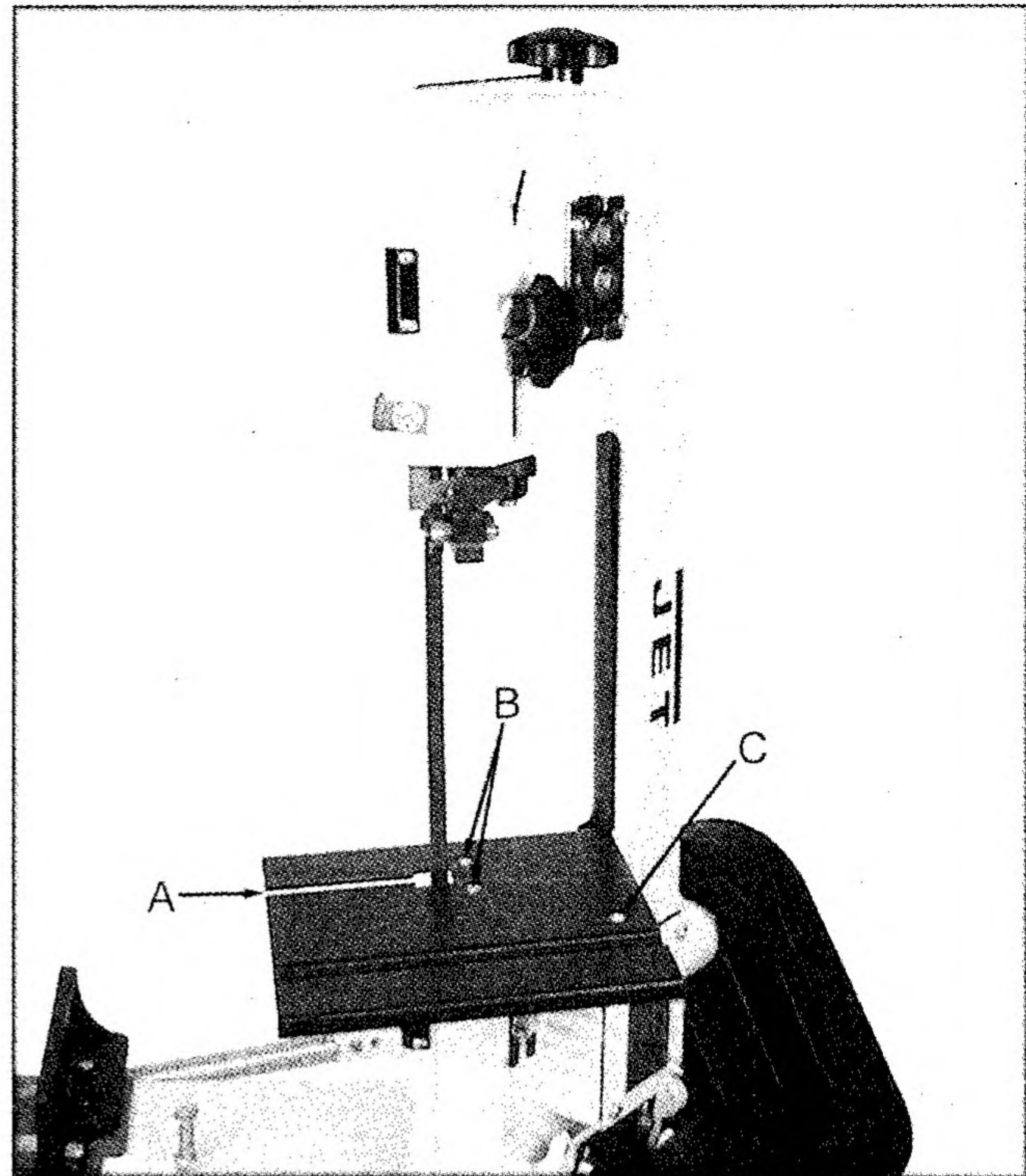


Fig. 8

Electrical Connections

⚠ WARNING

All electrical connections must be completed by a qualified electrician.
Failure to comply may cause serious injury!

The HVBS-56M band saw is rated at 115/230V and comes from the factory prewired 115V.

To switch to 230V operation, follow the wiring diagram found on the inside of the motor junction box. The plug on the end will have to be replaced with a plug that is rated at 230V.

Before hooking up to the power source, be sure the switch is in the off position.

Changing Blade Speed

1. Disconnect the machine from the power source.
2. Place saw arm in the horizontal position.
3. Loosen tensioning plate hex nut (A, Fig. 10).
4. Open pulley cover (B, Fig. 10). Lift motor with one hand while placing the belt (C, Fig. 10) on the desired pulley combination.
5. Tension belt by pressing down on the motor while tightening hex nut (A, Fig. 10) until finger pressure on the belt between the two pulleys causes approximately 1/2" deflection. Close pulley cover. Don't over tighten the belt.
6. Close pulley cover and connect to power source.

The general rule for band saw blade speed is the harder the material being cut, the slower the blade speed. Reference Figure 11 for a guide to blade speed for a type of material being cut.

Adjusting Blade Guides

1. Disconnect machine from the power source.
2. Loosen knob (A, Fig. 12) and slide blade guide assembly (B, Fig. 12), as close as possible without interference to the material being cut. Tighten knob.
3. Loosen bolt (C, Fig. 12) and slide blade guide assembly (D, Fig. 12), as close as possible without interference to the material being cut. Tighten bolt.

Adjusting Blade Tension

1. Disconnect machine from the power source.
2. Open blade cover and observe the position of the blade on the wheel. If the blade is not next to the wheel flange, adjust blade tracking following the steps under "Adjusting Blade Tracking".
3. If the blade is next to the wheel flange, loosen the blade guide assembly lock knob and hex head bolt (A & C, Fig. 12) and slide

the blade guide assemblies as far apart as possible. Lock in place.

4. Depress blade. Finger pressure should cause approximately .004" deflection. Turn blade tension knob (B, Fig. 12) until the proper tension is achieved. Re-position guides for cutting material.

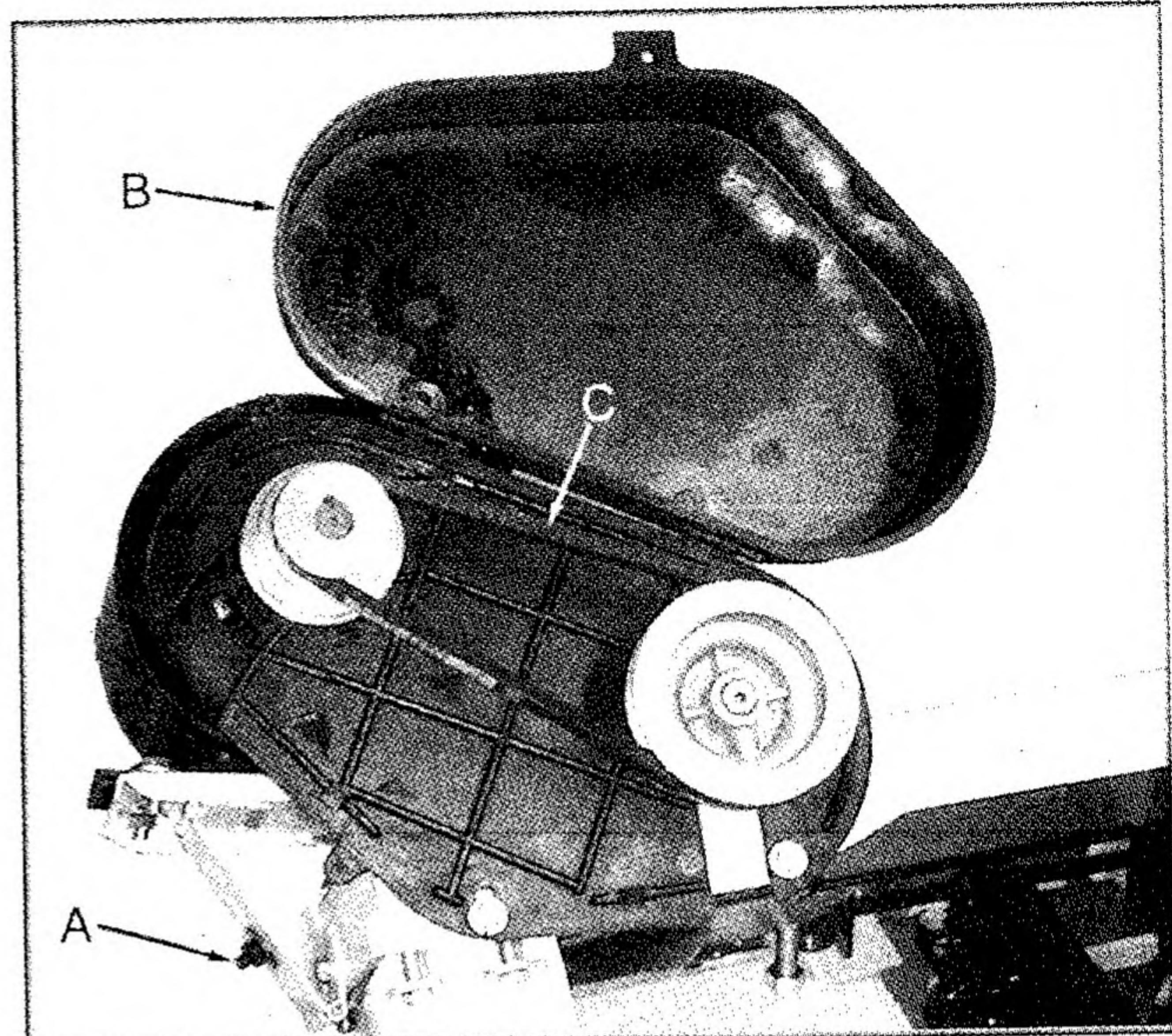


Fig. 10

| Material | Speed | Motor Pulley | Saw Pulley |
|--|---------|--------------|------------|
| Tool, Stainless, or Alloy Steel, Bearing Bronzes | 80 FPM | Small | Large |
| Mild Steel, Hard Brass, or Bronze | 120 FPM | Medium | Medium |
| Soft Brass, Aluminum, or other light materials | 200 FPM | Large | Small |

Fig. 11

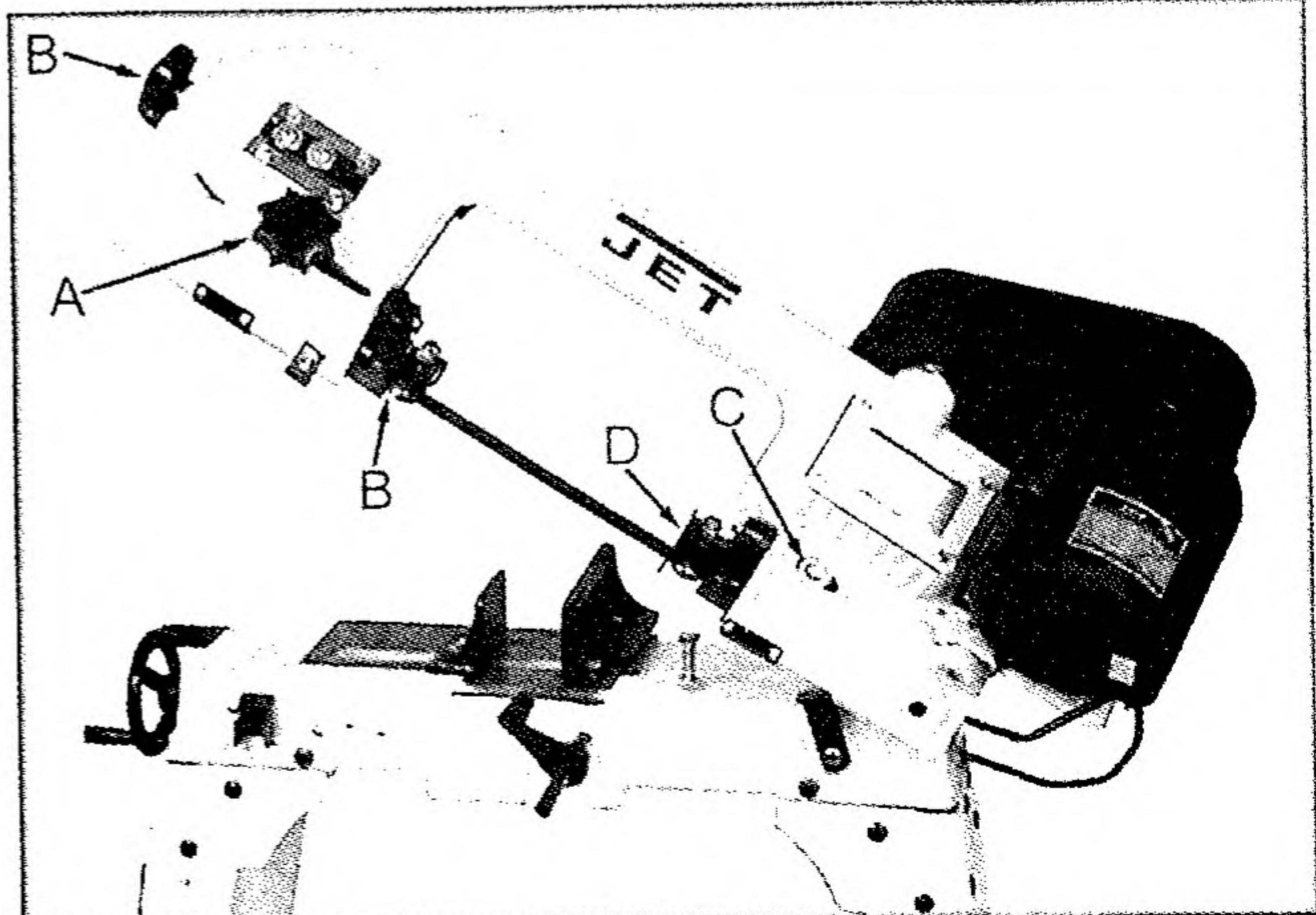


Fig. 12

Changing Blades

1. Disconnect machine from the power source.
2. Raise the saw arm to the vertical position and lock in place with lock lever.
3. Open blade cover by removing the small knob found on the topside of the bow.
4. Remove red blade guards by removing two screws.

⚠ WARNING

It is essential these two guards be installed after the new blade has been fitted. Failure to comply may cause serious injury!

5. Release tension on the blade by turning tensioning knob (B, Fig. 12), and remove the blade.
6. Place new blade between the blade guide assemblies and around each wheel. Make sure blade teeth are pointing in the proper direction, Figure 13. Tension enough to hold in place.
7. Install red blade guards with two screws.
8. Tension blade fully, see "Adjusting Blade Tension".
9. Place two to three drops of lightweight oil on the blade.
10. Connect machine to the power source.
11. Run saw and make sure blade is tracking properly, see "Adjusting Blade Tracking".

As a general rule, the thinner the material to be cut, the more teeth per inch on the blade. A minimum of three teeth should be in contact with the material at all times during the cut. If the teeth straddle the material, severe damage can result to the material and the blade.

Adjusting Blade Guide Bearings

1. Disconnect machine from the power source.
2. Loosen bolt (A, Fig. 14) and adjust assembly so that back roller bearing is approximately .002" - .003" from the back of the blade. Tighten bolt.

3. Loosen nut (B, Fig. 14) and turn nut (C, Fig. 14) to adjust eccentric bearing to a clearance of .001". Tighten nut (B, Fig. 14) to lock.

4. Connect machine to power source.

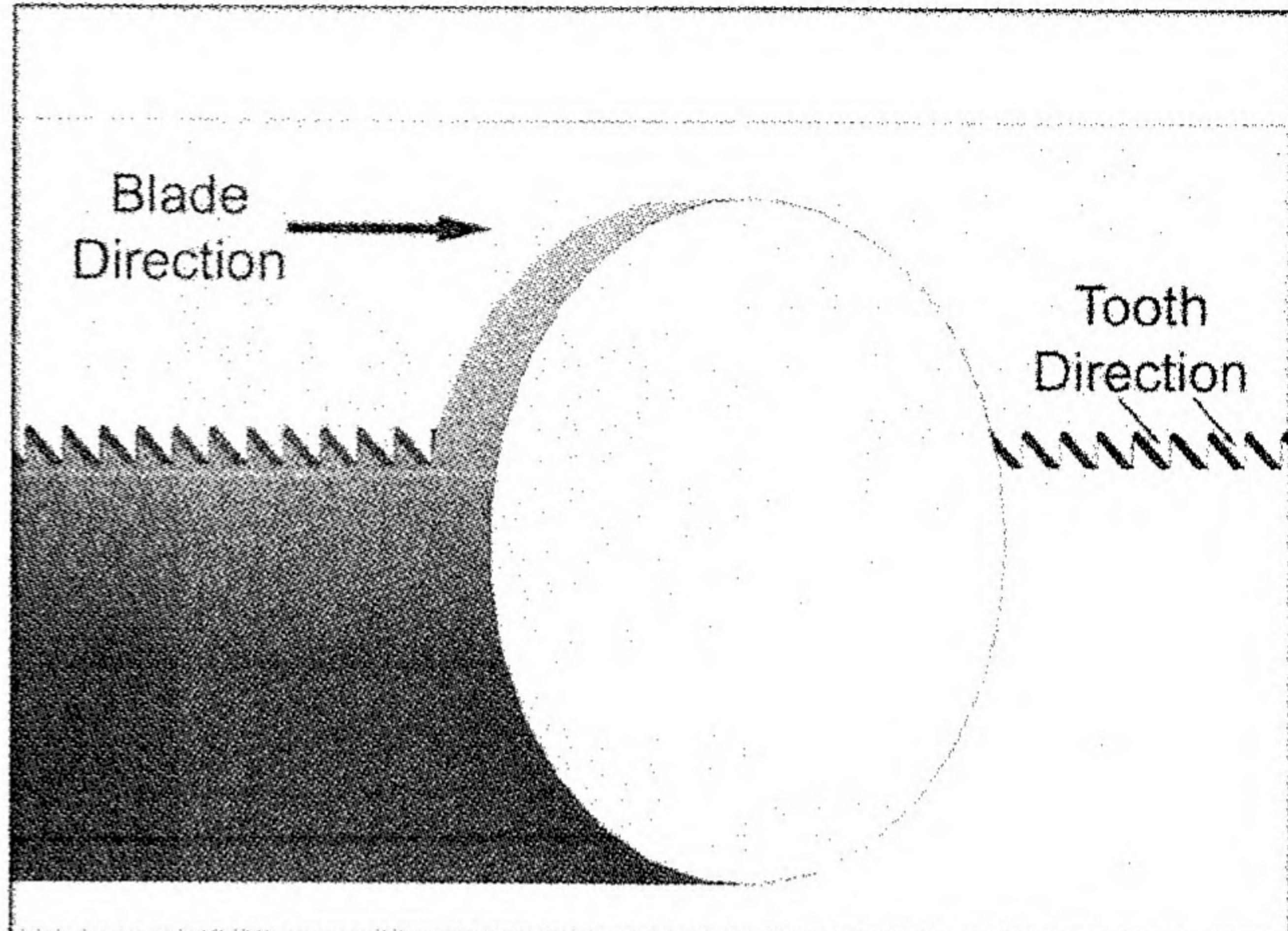


Fig. 13

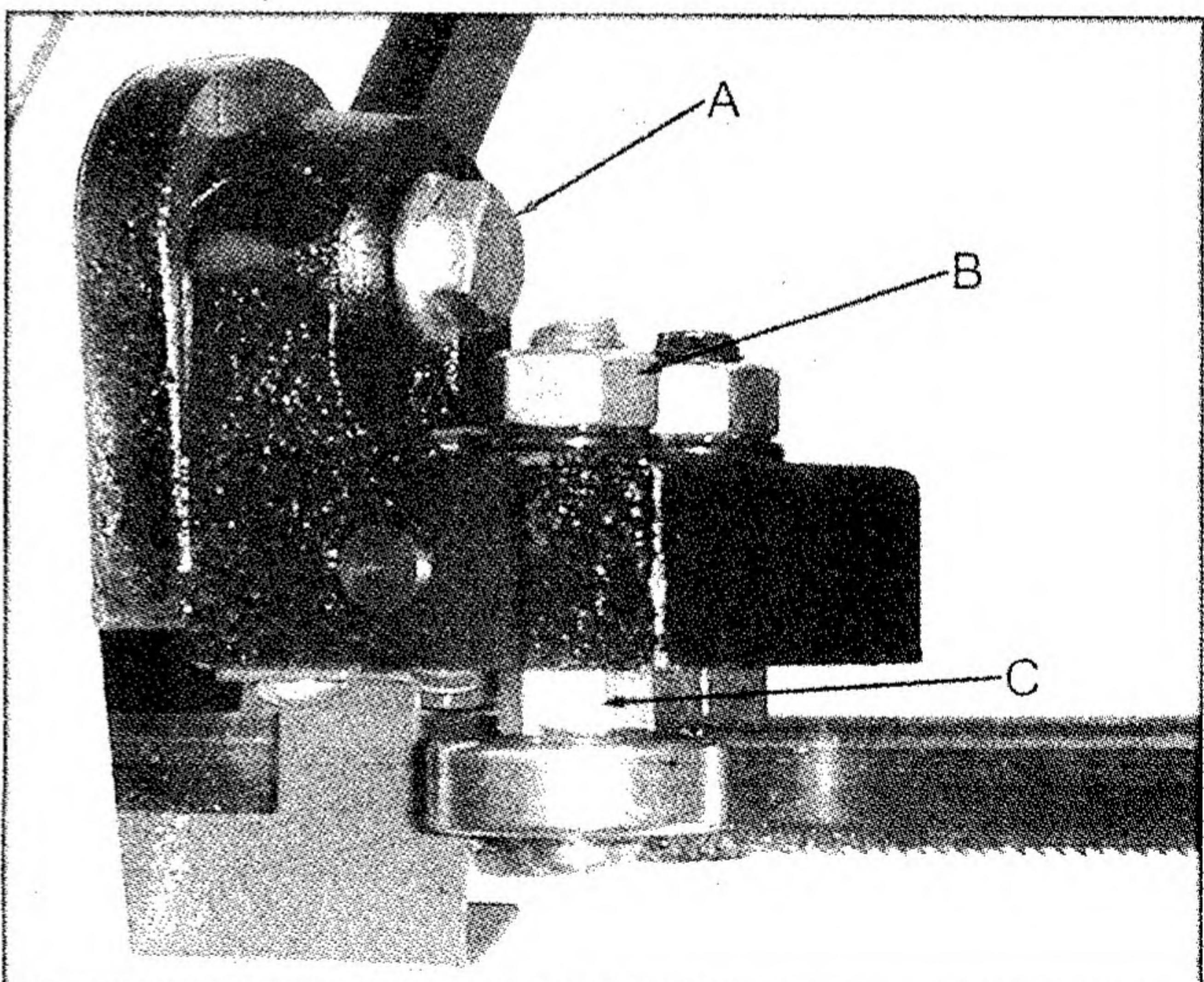


Fig. 14

Adjusting Blade Tracking

⚠ WARNING

Blade tracking adjustment requires running the saw with the back cover open! This adjustment must be completed by qualified persons only!
Failure to comply may cause serious injury!

Blade tracking has been set at the factory and should not need adjustment. If blade tracking needs to be adjusted:

1. Confirm that blade tension is set properly. To adjust, see section titled " Adjusting Blade Tension".
2. Make sure the saw is in its slowest speed, see "Changing Blade Speeds".
3. Move saw arm to the vertical position and lock in place with the lock lever.
4. Confirm that blade tension is set properly. To adjust, see section titled " Adjusting Blade Tension".
5. Open blade cover by removing the knob found on the top side of the bow.
6. Run saw and observe blade. Blade should run next to but not tightly against wheel flange.
7. Loosen bolts (A, Fig. 15).
8. Turn set screw (B, Fig. 15) while observing blade tracking on wheel. Turn set screw clockwise to track closer to wheel flange. Turn set screw counter-clockwise to track away from the wheel flange. **Hint:** start with $\frac{1}{4}$ turns on the set screw. The tracking is sensitive.
9. Once tracking is set, tighten bolts (A, Fig. 15).

Adjusting Feed Pressure

1. Turn handle (A, Fig. 16) clockwise to decrease cutting pressure and counter-clockwise to increase cutting pressure.

A good indication of proper feed pressure is the color and shape of the cutting chips. If the chips are thin or powdered, increase the feed pressure. If the chips are burned and heavy, decrease the

feed pressure. If they are still burned and heavy, reduce the blade speed. Optimum feed pressure has been set when the chips are curled, silvery, and warm.

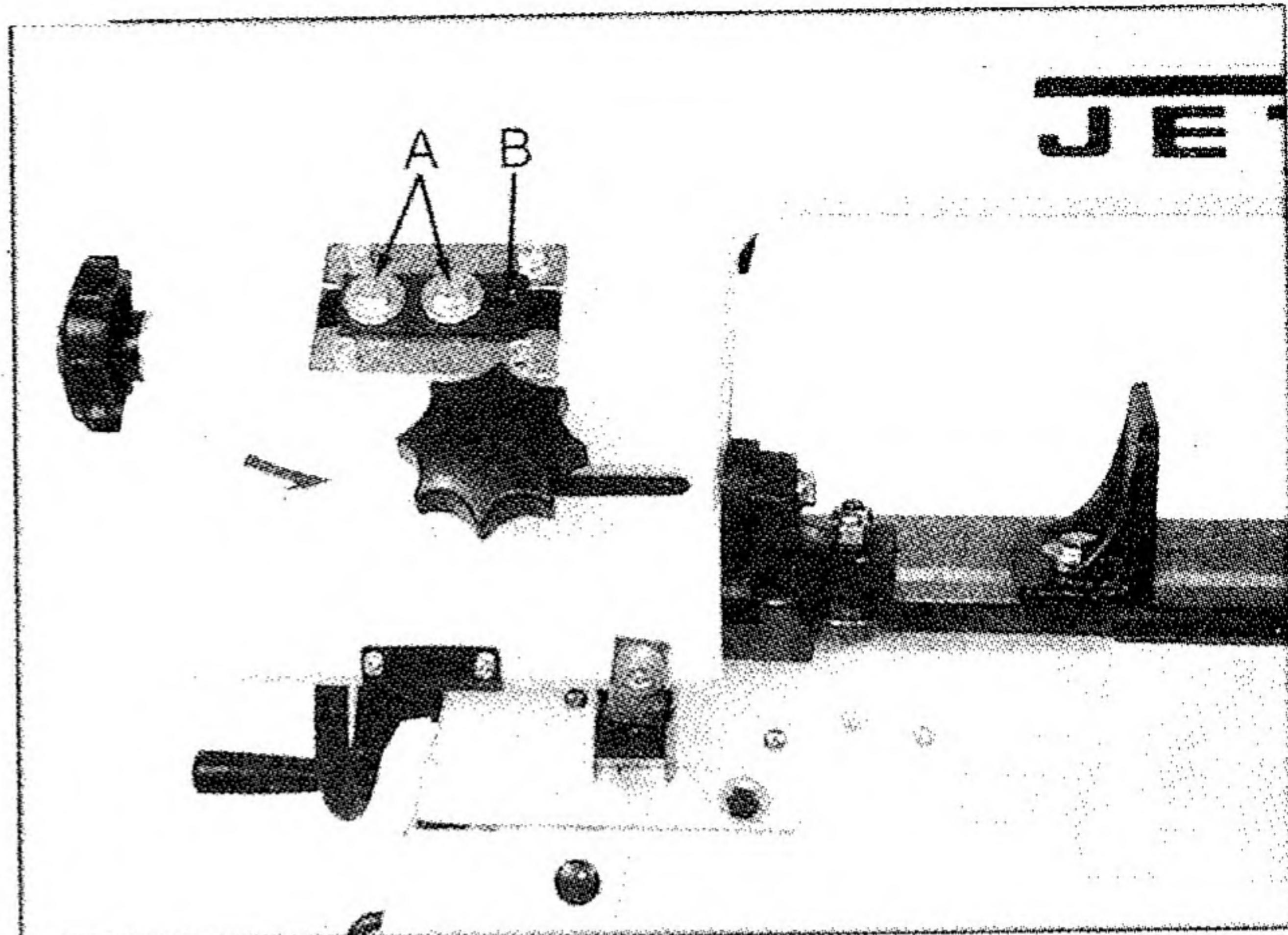


Fig. 15

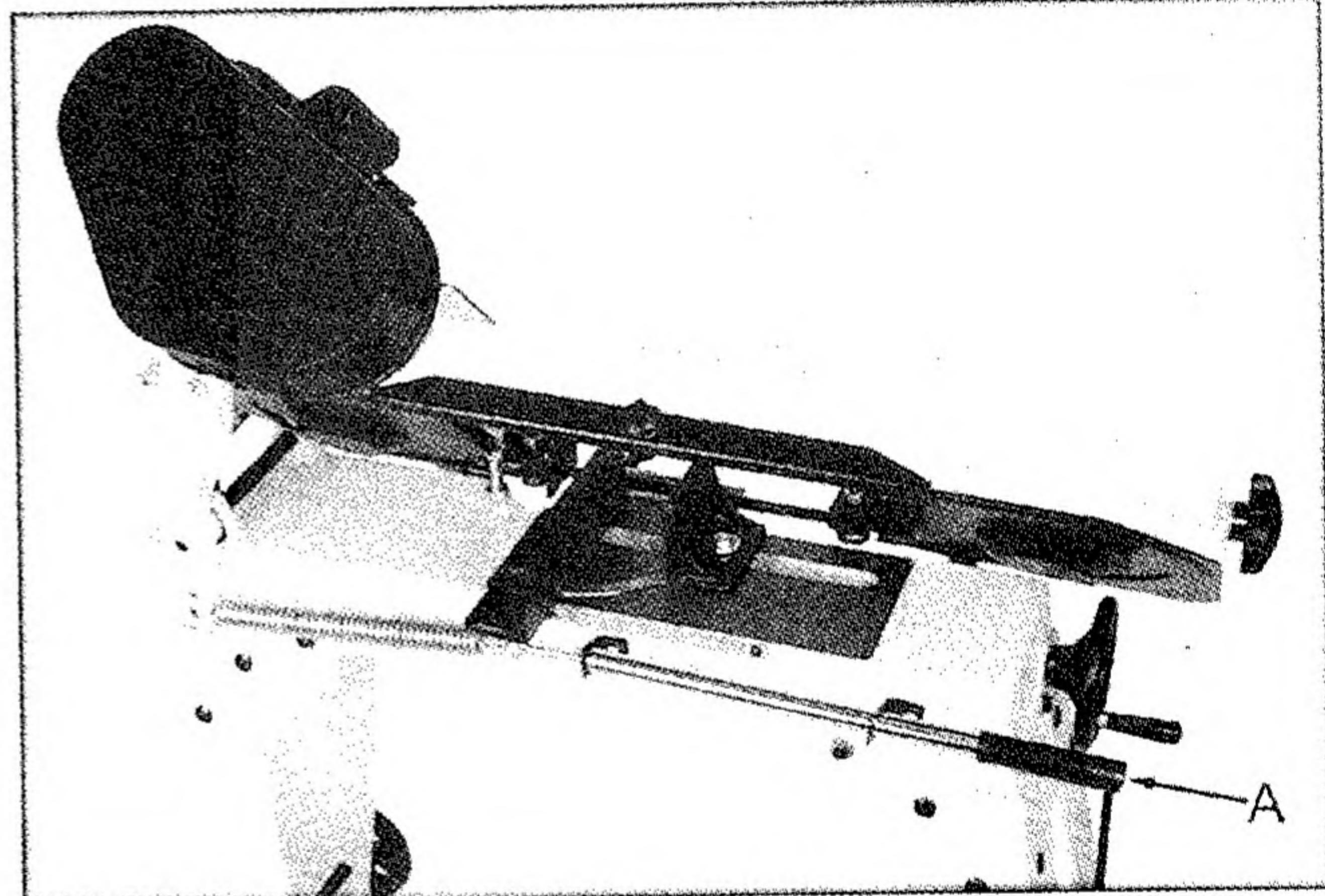


Fig. 16

Adjusting Automatic Shut-Off

The saw should stop after the cut has been completed:

- If the saw completes the cut and continues to run, adjust the stop tip (A, Fig. 17) down.
- If the saw shuts off before the cut is complete, adjust the stop tip (A, Fig. 17) up.
- If the saw stops cutting but continues to run, adjust the stop bolt (B, fig. 17) down.

The saw is properly adjusted when the saw shuts off just after the blade has finished the cut.

2. Place saw arm in the horizontal position.
3. Remove screws (A, Fig. 18) from the gear box and remove cover plate and gasket.
4. Hold a container under the lower right corner of the gear box with one hand while slowly raising the saw arm with the other. Drain completely.
5. Place arm in the horizontal position. Wipe out remaining oil with a rag.
6. Fill gear box with approximately 1/2 pint of MOBIL SHC 634.
7. Replace gasket and cover. Fasten cover with bolts.

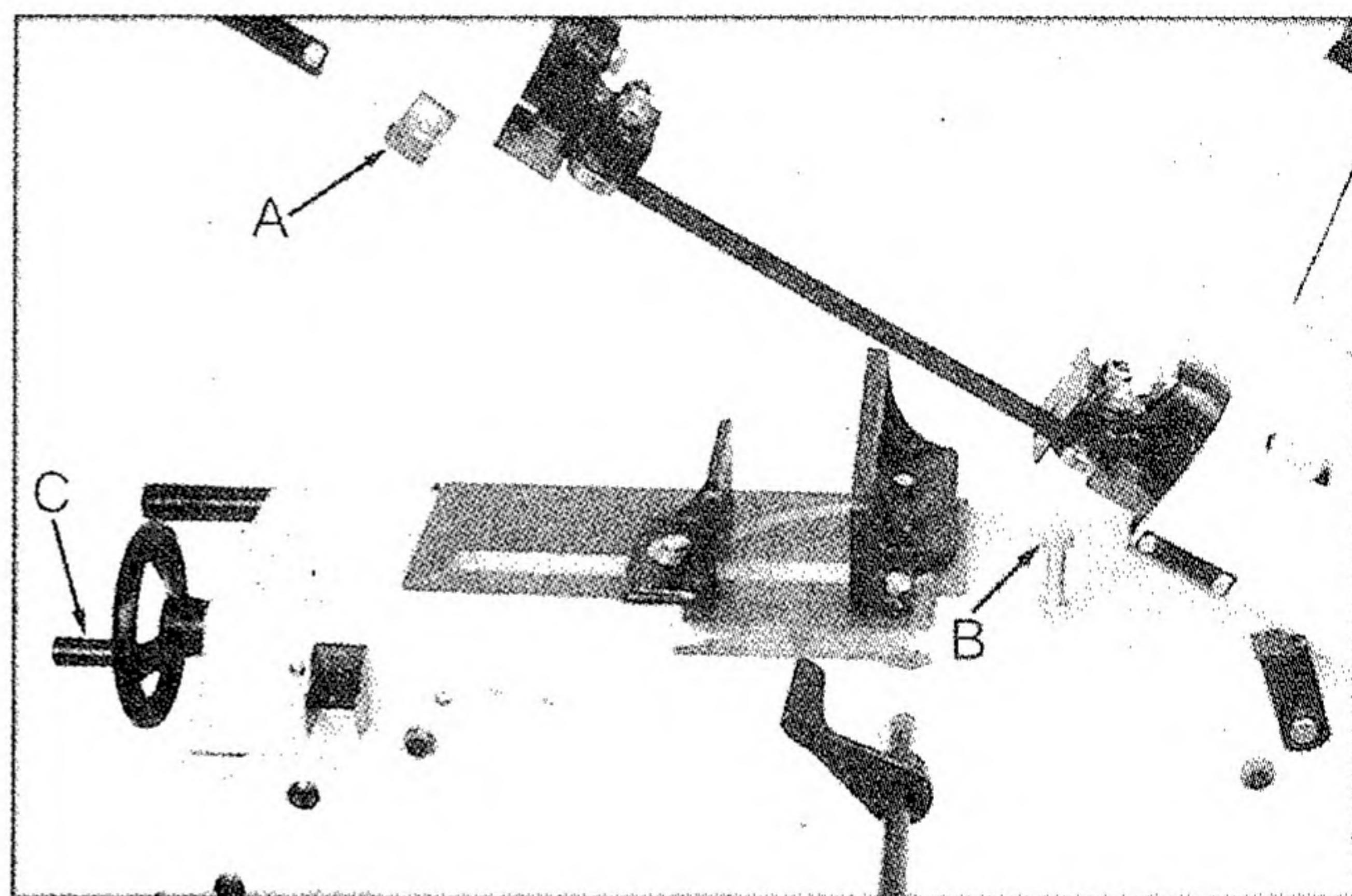


Fig. 17

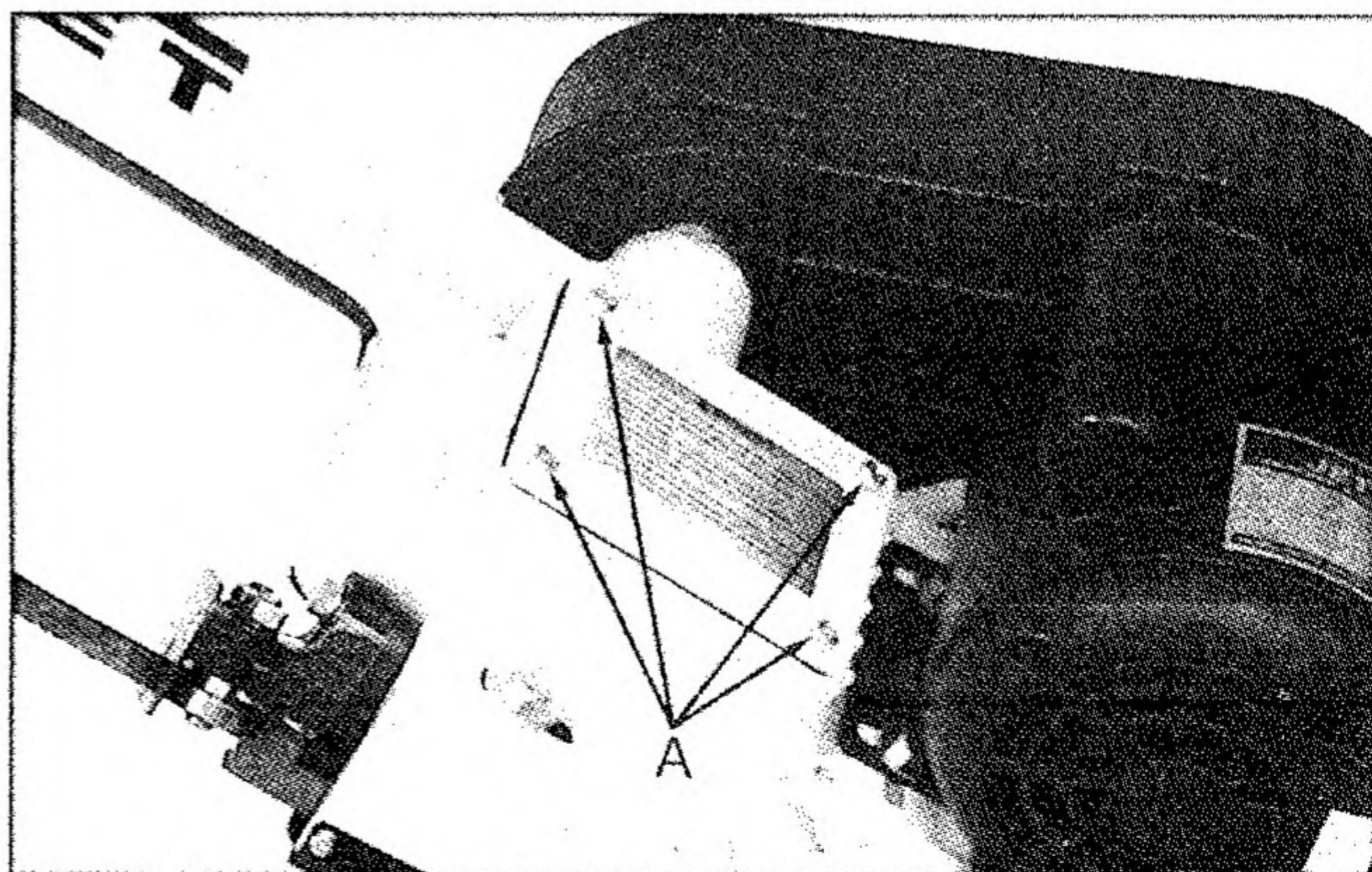


Fig. 18

Lubrication

Ball bearings on the blade guide assemblies and the blade wheels are permanently sealed and require no lubrication.


Lubricate the vise lead screw as needed with #2 tube grease.

Gear box oil will have to be changed after 90 days of operation. There after, change every six months.


To change the gear box oil:

1. **Disconnect machine from the power source.**

Breakdown for Bow Assembly



Breakdown for Base Assembly



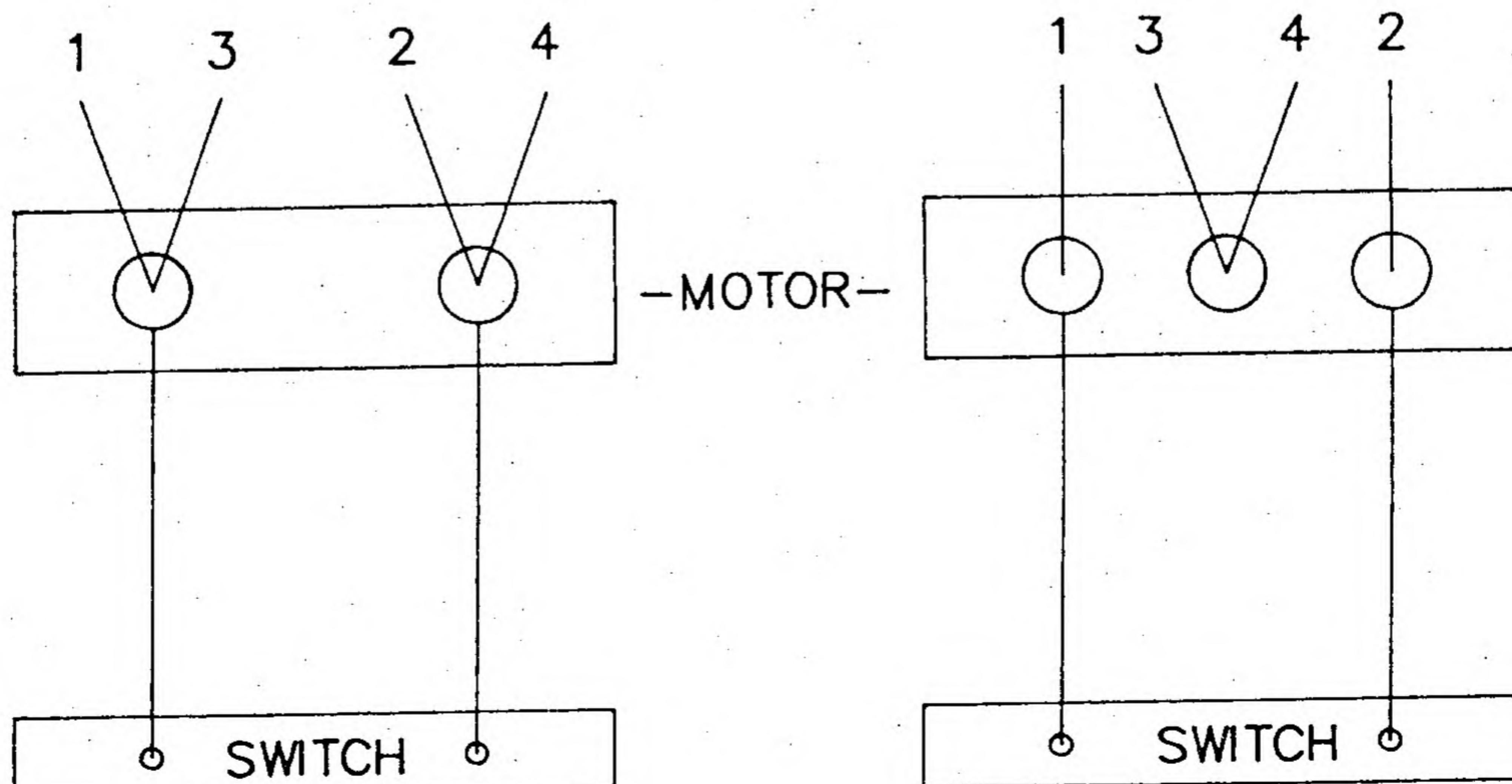
Parts List for the HVBS-56M Band saw

| Index | Part | Description | Size | Qty. |
|-------|---------------|------------------------|-------------|------|
| No. | No. | | | |
| 1 | TS-0051031 | Hex Cap Bolt | 5/16"x3/4" | 4 |
| 2 | TS-0561011 | Hex Nut | 1/4" | 1 |
| 3 | TS-0680021 | Flat Washer | 1/4" | 5 |
| 4 | HVBS56M-04 | Stand Leg | | 4 |
| 4-1 | HVBS56M-04-1 | Cross Brace | | 2 |
| 5 | HVBS56M-05 | Washer | | 6 |
| 6 | HVBS462-006 | Cotter Pin | 1/8"x1" | 4 |
| 7 | HVBS56M-07 | Axle | | 1 |
| 8 | TS-0680031 | Flat Washer | 5/16" | 36 |
| 9 | HVBS56M-09 | Wheel | | 2 |
| 10 | HVBS56M-010 | Washer | 1/4"x5/8" | 1 |
| 11 | TS-0051051 | Hex Cap Bolt | 5/16"x1" | 4 |
| 11-1 | HVBS56M-11-1 | Carriage Bolt | 5/16"x3/4" | 16 |
| 11-2 | TS-0051051 | Hex Cap Bolt | 5/16"x1" | 6 |
| 12 | TS-0561021 | Hex Nut | 5/16" | 22 |
| 13 | HVBS56M-013 | Adjustable Foot | | 2 |
| 14 | HVBS462-014 | Floor Stand Handle | | 1 |
| 15 | HVBS462-015 | Adjusting Rod | | 1 |
| 16 | HVBS462-016 | Electric Cord | | 1 |
| 17 | HVBS462-017 | Pivoting Rod | | 1 |
| 18 | HVBS462-018 | Support Plate | | 1 |
| 19 | HVBS462-019 | Stock Stop | | 1 |
| 20 | TS-0270021 | Socket Set Screw | 5/16"x5/16" | 4 |
| 21 | HVBS462-021 | Stock Stop Rod | | 1 |
| 22 | HVBS462-022 | Wire Relief Retainer | | 2 |
| 25 | TS-0051031 | Hex Cap Bolt | 5/16"x3/4" | 1 |
| 27 | HVBS462-027 | Wheel Handle | | 1 |
| 28 | HVBS462-028 | Hand Wheel | | 1 |
| 29 | HVBS56M-029 | Toggle Switch Assembly | | 1 |
| 29-1 | HVBS56M-029-1 | Plastic Cover | | 1 |
| 30 | HVBS462-030 | E-Ring | E10 | 1 |
| 31 | HVBS462-031 | Screw | 5/16"x1" | 3 |
| 32 | HVBS462-032 | Lead Screw | | 1 |
| 33 | HVBS462-033 | Vise Nut | | 1 |
| 34 | HVBS462-034 | Moveable Vise Plate | | 1 |
| 35 | TS-0680041 | Flat Washer | 3/8"x1" | 4 |
| 36 | TS-0090061 | Hex Cap Bolt | 3/8"x1-1/4" | 1 |
| 37 | HVBS462-037 | Bed | | 1 |
| 38 | HVBS462-038 | Cross Round Head Screw | 3/16"x3/8" | 2 |
| 39 | HVBS462-039 | Scale | | 1 |
| 40 | HVBS462-040 | Electric Cord Clip | | 1 |
| 42 | HVBS56M-042 | Screw | M4x16 | 2 |
| 43 | HVBS462-043 | Rubber Ring | | 1 |
| 44 | HVBS462-044 | Electric Cable | | 1 |
| 45 | HVBS462-045 | Nut Plate | | 1 |
| 45-1 | HVBS56M-045-1 | Spring Handle Bracket | | 1 |
| 46 | HVBS462-046 | Spring Adjusting Screw | | 1 |
| 47 | HVBS462-047 | Spring | | 1 |
| 48 | HVBS462-048 | Cross Round Head Screw | 3/16"x3/8" | 4 |
| 49 | HVBS462-049 | Mitering Vise Plate | | 1 |
| 50 | TS-0081031 | Hex Cap Bolt | 5/16"x3/4" | 6 |
| 51 | TS-0680031 | Flat Washer | 5/16" | 3 |

| Index | Part | Description | Size | Qty. |
|-------|----------------|--|--------------|------|
| No. | No. | | | |
| 52 | TS-0081071 | Hex Cap Bolt | 5/16"x1-1/2" | 1 |
| 53 | TS-0091071 | Hex Cap Screw | 7/16"x2" | 1 |
| 54 | HVBS56M-054 | Pivot Bracket | | 1 |
| 55 | HVBS462-055 | Vertical Cutting Plate | | 1 |
| 56 | HVBS462-056 | Stand for Vertical Cutting Plate | | 1 |
| 57 | HVBS56M-057 | Adjustable Bracket Assembly LH | | 1 |
| 58 | HVBS462-058 | Knob | 1/4" | 2 |
| 59 | HVBS56M-059A | Blade Back Safety Cover | | 1 |
| 60 | HVBS462-060 | C-Clip | S10 | 4 |
| 61 | BB-6000ZZ | Ball Bearing | 6000ZZ | 6 |
| 62 | HVBS462-062 | Guide Pivot | | 2 |
| | HVBS462-062A | Center Shaft Assembly (Includes: #60-62) | | 1 |
| 62-1 | HVBS462-062-1 | Centrifugal Guide Pivot | | 2 |
| | HVBS462-062-1A | Eccentric Shaft Assembly (Includes: #60,61,62-1) | | 1 |
| 63 | HVBS462-063 | Bearing Shaft Pin | | 2 |
| 64-1 | HVBS462-064-1 | Blade Seat Left | | 1 |
| 64-2 | HVBS462-064-2 | Blade Seat Right | | 1 |
| 65 | HVBS56M-065 | Adjustable Bracket-Assembly RH | | 1 |
| 66 | HVBS462-066 | Lock Knob | | 1 |
| 67 | TS-0720081 | Lock Washer | 5/16" | 3 |
| 68 | TS-0813051 | Flat Head Machine Screw | 1/4"X3/4" | 3 |
| 69 | HVBS462-069 | Bearing Guard | | 1 |
| 70 | TS-0561031 | Hex Nut | 3/8" | 4 |
| 71 | HVBS462-071 | Blade Wheel Drive | | 1 |
| 72 | HVBS462-072 | Bearing Cover | | 2 |
| 73 | HVBS462-073 | Key | 5x5x25 | 2 |
| 74 | HVBS56M-060 | C-Clip | S15 | 1 |
| 75 | HVBS462-075 | Hex Cap Bolt (w/Washer) | 1/4"x1/2" | 8 |
| 76 | HVBS462-076 | Switch Cut Off Trip | | 1 |
| 77 | HVBS462-077 | Idle Blade Wheel | | 1 |
| 78 | TS-0680031 | Flat Washer | 5/16" | 2 |
| 79 | HVBS462-079 | Blade Tension Knob | 3/8" | 1 |
| 80 | HVBS462-080 | Spring | | 1 |
| 81 | HVBS56M-081 | Saw Bow | | 1 |
| 82 | HVBS56M-082 | Washer | | 1 |
| 83 | TS-0070031 | Cap Screw | 1/2"x1-1/2" | 2 |
| 84 | HVBS56M-084 | Motor Mount Plate | | 1 |
| 84-1 | HVBS56M-084-1 | Tension Bracket | | 1 |
| 85 | HVBS463-085 | Motor | 1/2 HP, 1Ph | 1 |
| | HVBS463-085-01 | Capacitor Cover (not shown) | | 1 |
| | HVBS462-085-02 | Capacitor (not shown) | | 1 |
| 86 | HVBS462-086 | Motor Pulley | | 1 |
| 87 | BB-6202ZZ | Ball Bearing | 6202ZZ | 6 |
| 88 | HVBS462-088 | Bearing Bushing | | 1 |
| 89 | OS-15375 | Oil Seal | | 2 |
| 90 | HVBS462-090 | Transmission Wheel Shaft | | 1 |
| 91 | HVBS462-091 | Worm Gear | | 1 |
| 92 | HVBS462-092 | Gear Box Gasket | | 1 |
| 93 | HVBS462-093 | Gear Box Cover | | 1 |
| 94 | HVBS462-094 | Worm Gear (w/Shaft) | | 1 |
| 95 | HVBS462-095 | Spring Pin | | 1 |
| 96 | HVBS462-096 | Bearing Bushing | | 1 |
| 97 | TS-0050011 | Hex Cap Bolt | 1/4"x1/2" | 3 |
| 98 | HVBS56M-098 | Clamp | | 2 |

| Index No. | Part No. | Description | Size | Qty. |
|-----------|--------------|-------------------------------|-------------|------|
| 99 | HVBS462-099 | Spacer | | 1 |
| 100 | HVBS462-100 | Flat Cross Head Screw | 5/32"x3/8" | 8 |
| 101 | HVBS462-101 | Worm Gear Pulley | | 1 |
| 102 | TS-0720081 | Lock Washer | 5/16" | 2 |
| 103 | HVBS462-103 | Blade Tension Sliding Plate | | 1 |
| 104 | TS-0270051 | Socket Set Screw | 5/16"x1/2" | 3 |
| 105 | HVBS462-105 | Spring Pin | | 1 |
| 106 | HVBS462-106 | Sliding Plate Draw Block | | 1 |
| 107 | HVBS462-107 | Blade Wheel Shaft | | 1 |
| 108 | HVBS462-108 | Shaft Block | | 1 |
| 109 | HVBS462-109 | Blade Tension Sliding Guide | | 2 |
| 110 | HVBS462-110 | Motor Pulley Cover Assembly | | 1 |
| 111 | TS-0680031 | Flat Washer | 5/16" | 1 |
| 112 | VB-A22 | V-Belt | A22 | 1 |
| 113 | 414301 | Blade | | 1 |
| 114 | TS-0680041 | Flat Washer | 3/8" | 4 |
| 115 | TS-0561011 | Hex Nut | 1/4" | 1 |
| 116 | HVBS463-170 | Wire Plug | | 3 |
| 117 | HVBS463-171 | Hex Screw | 3/8"x1-1/4" | 1 |
| 120 | HVBS462-120 | Bushing | | 1 |
| 122 | TS-0561041 | Hex Nut | 7/16" | 1 |
| 123 | TS-0050031 | Cap Screw | 1/4"x3/4" | 1 |
| 124 | HVBS463-124 | Machine Screw | 3/16"x3/4" | 2 |
| 126 | HVBS462-126 | Bushing | | 1 |
| 132 | HVBS462-132 | Blade Guard-Right | | 1 |
| 132-1 | HVBS462-132A | Blade Guard-Left | | 1 |
| 156 | HVBS462-156 | Round Head Screw | 3/16"x3/4" | 1 |
| 157 | HVBS462-157 | Star Washer | 3/16" | 3 |
| 158 | HVBS463-158 | Hex Nut | 3/16" | 2 |
| | HVBS56M-BS | Blade Speed Label (not shown) | | 1 |
| | HVBS56M-ID | I.D. Label (not shown) | | 1 |
| | HVBS56M-WL | Warning Label (not shown) | | 1 |
| | JM-56M | Stripe Decal (not shown) | | 1 |

Wiring Diagram



115V

230V



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